

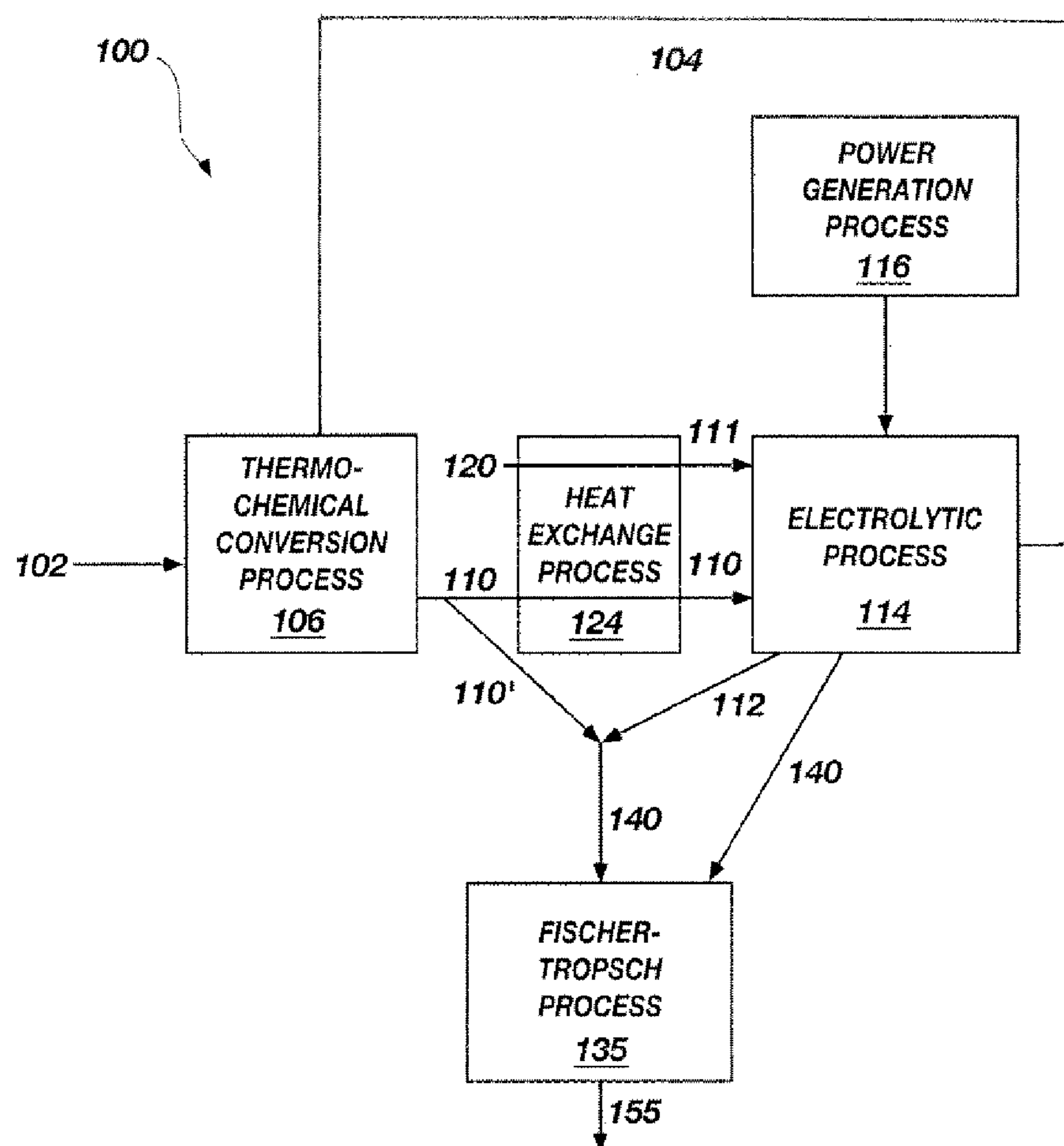


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(19) **United States**(12) **Patent Application Publication**
Hawkes et al.(10) **Pub. No.: US 2009/0235587 A1**(43) **Pub. Date: Sep. 24, 2009**(54) **METHODS AND SYSTEMS FOR PRODUCING SYNGAS**(21) Appl. No.: **12/054,269**(22) Filed: **Mar. 24, 2008**(75) Inventors: **Grant L. Hawkes**, Sugar City, ID (US); **James E. O'Brien**, Idaho Falls, ID (US); **Carl M. Stoots**, Idaho Falls, ID (US); **J. Stephen Herring**, Idaho Falls, ID (US); **Michael G. McKellar**, Idaho Falls, ID (US); **Richard A. Wood**, Idaho Falls, ID (US); **Robert A. Carrington**, Idaho Falls, ID (US); **Richard D. Boardman**, Idaho Falls, ID (US)**Publication Classification**(51) **Int. Cl.**
C10J 3/16 (2006.01)(52) **U.S. Cl.** **48/202; 48/61**(57) **ABSTRACT**

Methods and systems are provided for producing syngas utilizing heat from thermochemical conversion of a carbonaceous fuel to support decomposition of at least one of water and carbon dioxide using one or more solid-oxide electrolysis cells. Simultaneous decomposition of carbon dioxide and water or steam by one or more solid-oxide electrolysis cells may be employed to produce hydrogen and carbon monoxide. A portion of oxygen produced from at least one of water and carbon dioxide using one or more solid-oxide electrolysis cells is fed as a controlled flow rate in a gasifier or combustor to oxidize the carbonaceous fuel to control the carbon dioxide to carbon monoxide ratio produced.

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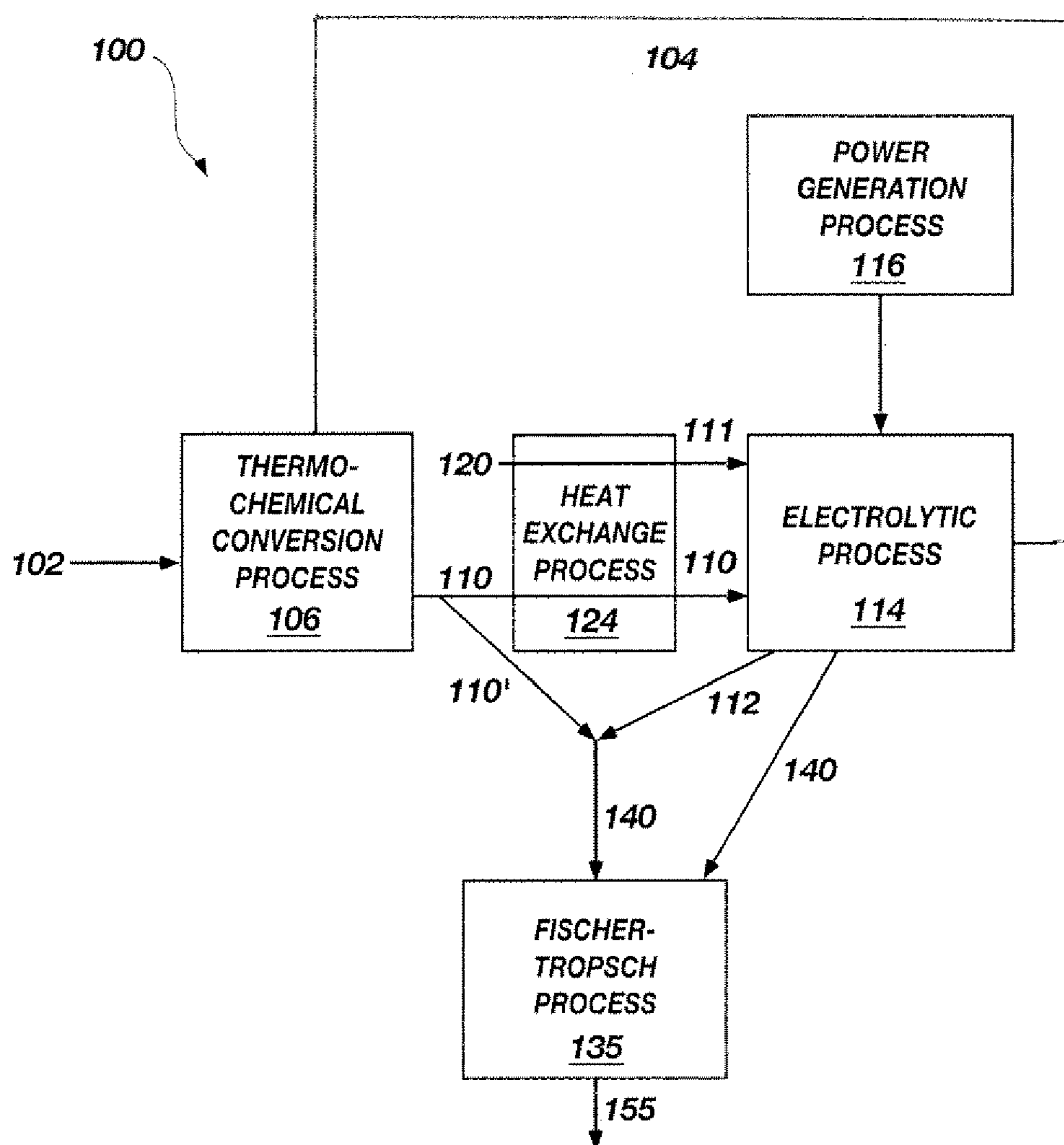


FIG. 1

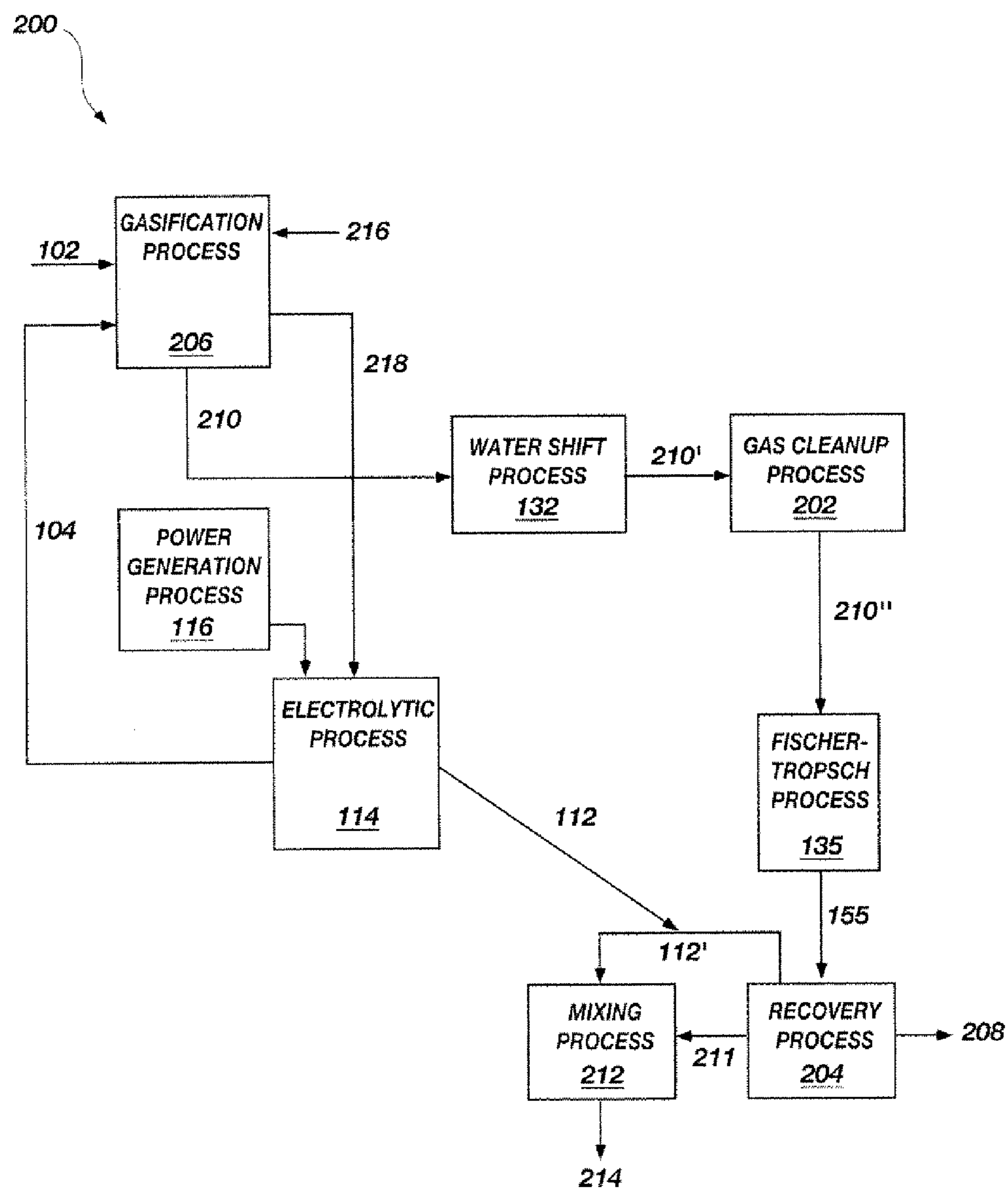


FIG. 2

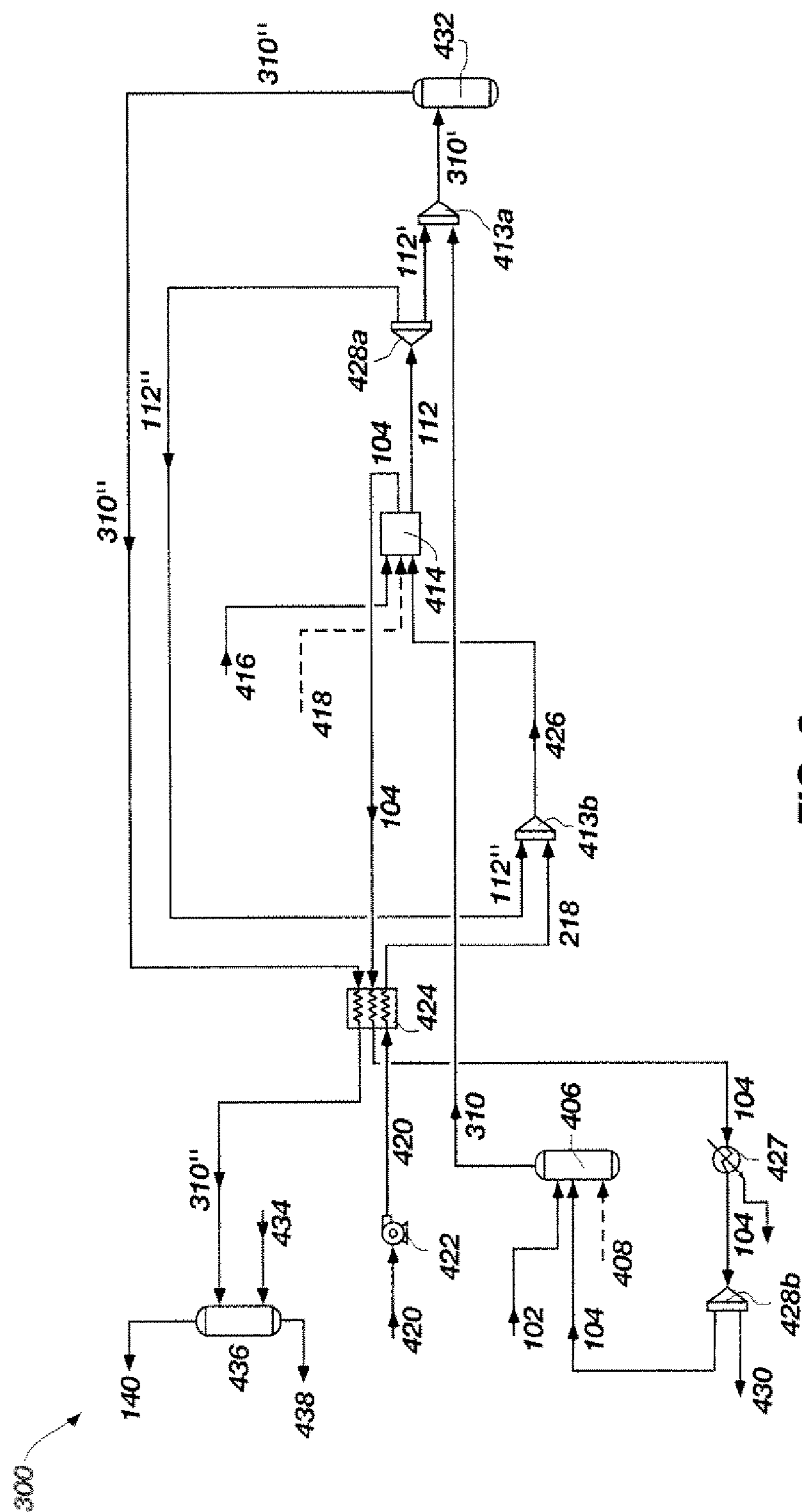


FIG. 3

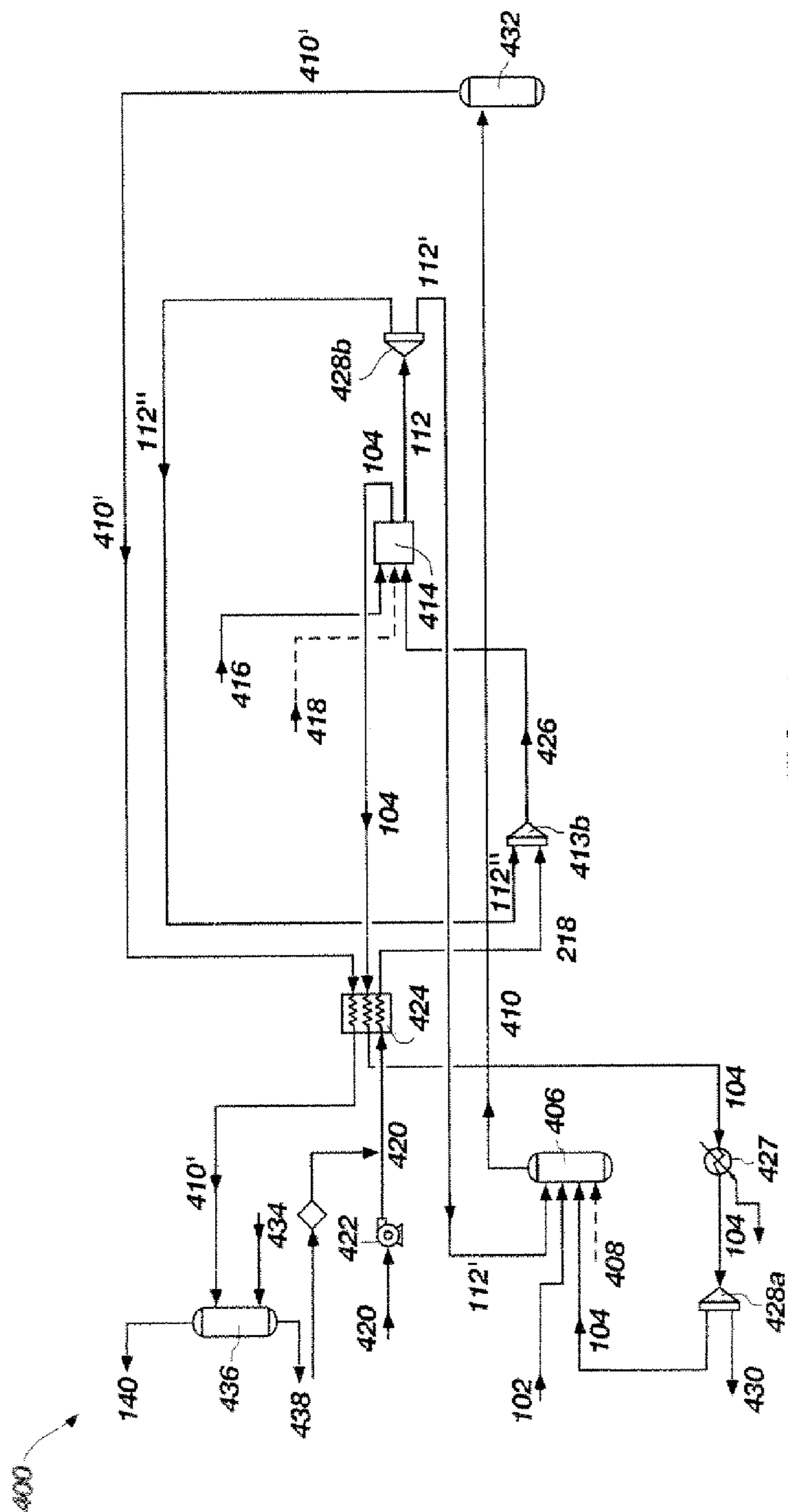


FIG. 4

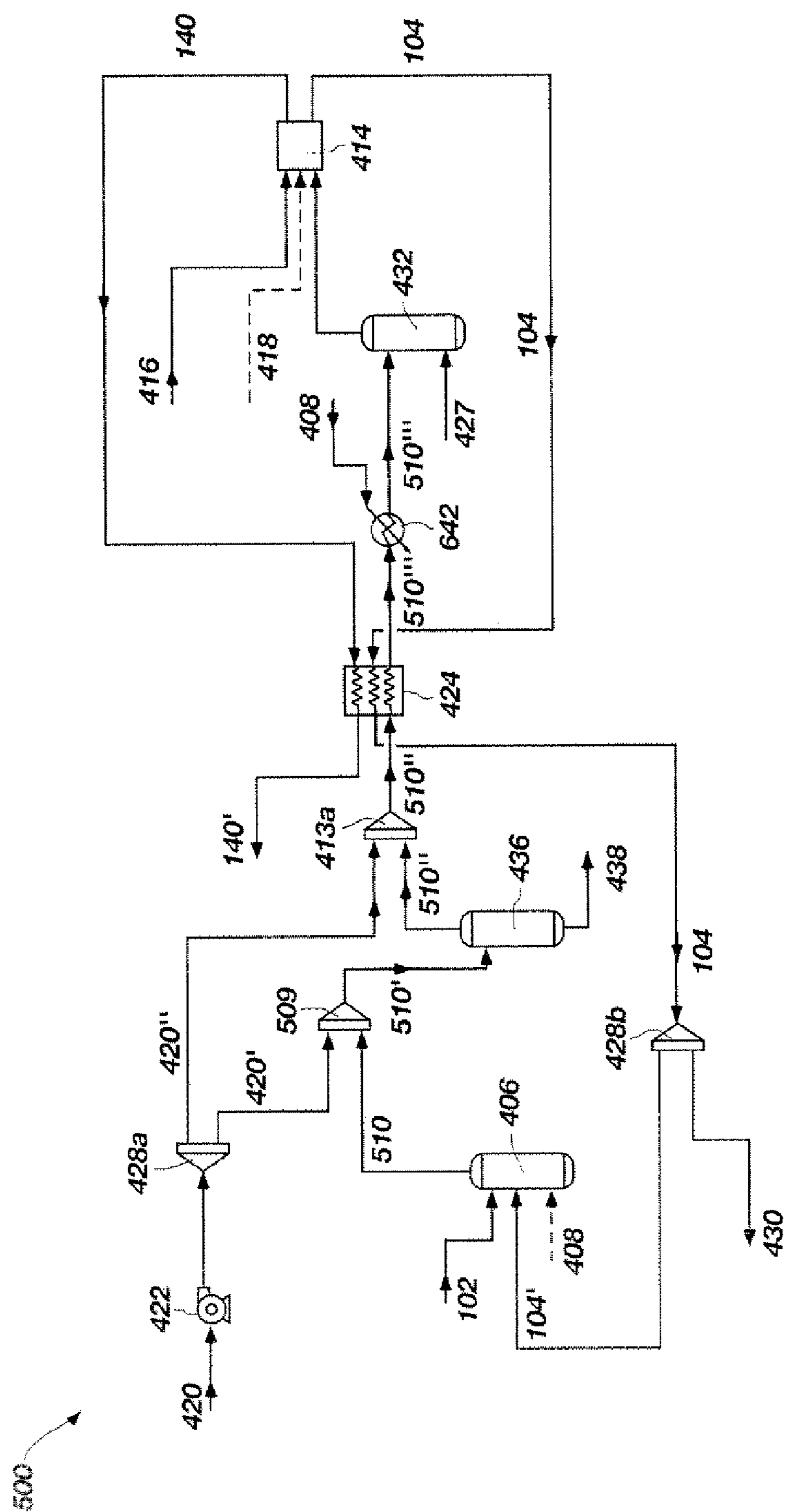


FIG. 5

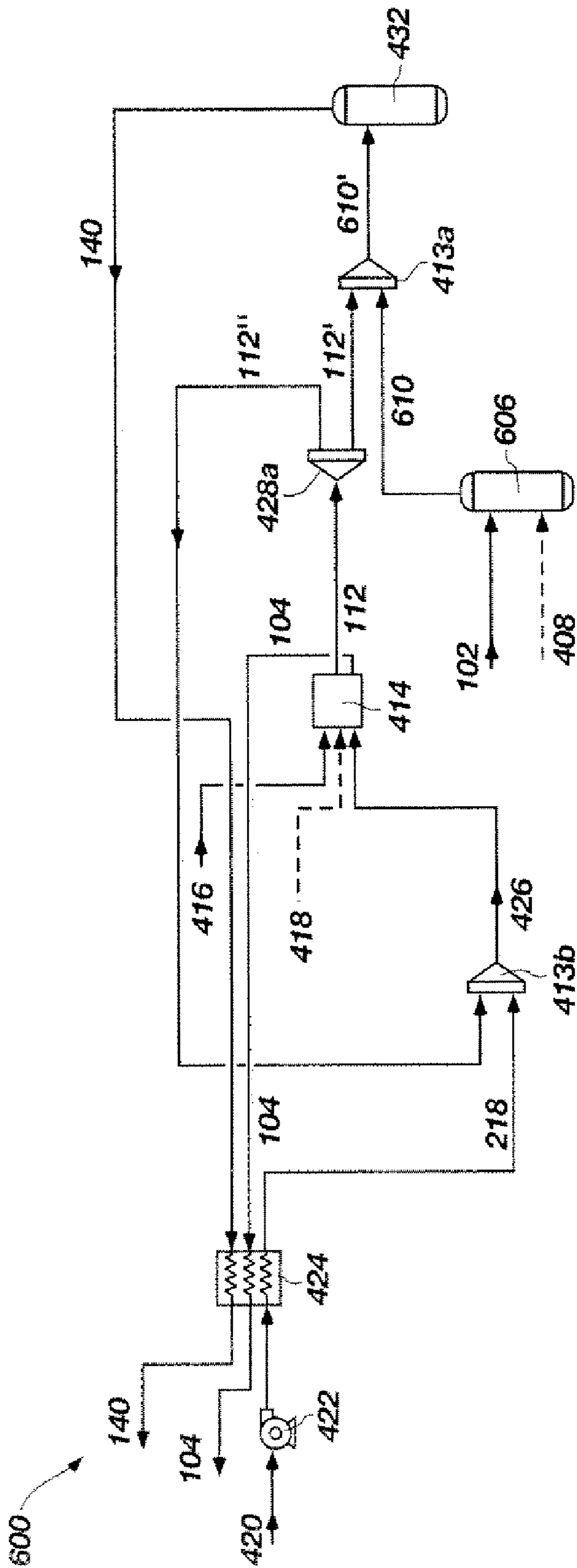


FIG. 6

METHODS AND SYSTEMS FOR PRODUCING SYNGAS

GOVERNMENT RIGHTS

[0001] The United States Government has certain rights in this invention pursuant to Contract No. DE-AC07-05-ID14517, between the United States Department of Energy and Battelle Energy Alliance, LLC.

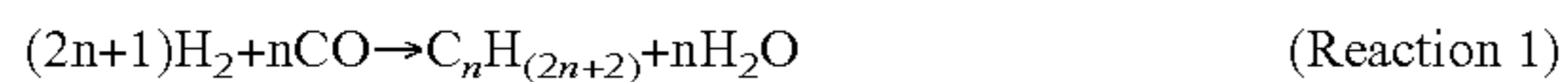
TECHNICAL FIELD

[0002] Embodiments of the present invention relate, generally, to the production of syngas and, more particularly, to methods and systems for producing syngas from a carbonaceous fuel, such as biomass, coal, or other solid or nonconventional heavy hydrocarbons by utilizing the heat from thermochemical conversion of the carbonaceous fuel to support electrolysis of steam and/or co-electrolysis of steam and carbon dioxide in one or more solid-oxide electrolysis cells.

BACKGROUND

[0003] As energy consumption in the United States and throughout the world continues to increase, additional methods for environmentally clean energy conversion that can convert biomass, coal, or other solid or nonconventional heavy hydrocarbon energy resources to hydrogen, synthetic fuels and chemicals are desired. Concerns about the increased wastes and pollutants produced by many of the conventional energy conversion processes, and the low efficiencies of such processes, have led to further research for cleaner, more efficient processes.

[0004] In response to the increasing energy demands and the desire to reduce or eliminate pollutants, new cleaner, energy conversion processes that can utilize biomass, coal, or other solid or nonconventional heavy hydrocarbons are being sought. A known process for conversion of these energy resources to cleaner fuels includes synthetic fuels, often referred to as “synfuels,” which are made from synthesis gas, often referred to as “syngas.” Syngas includes a mixture of varying amounts of carbon monoxide (CO) and hydrogen (H₂) that may be converted to form hydrogen, synfuels, methanol or chemicals. Production of synfuels from syngas may be performed using a variety of processes including a Fischer-Tropsch process to convert the carbon monoxide and hydrogen into liquid hydrocarbons as shown below in Reaction 1:



[0005] The synfuels produced using the Fischer-Tropsch process may include high purity, low sulfur, fuels, often referred to as “Fischer-Tropsch liquids,” which have fewer pollutants than naturally occurring fuels or fuels processed from naturally occurring oil deposits.

[0006] Another approach is to convert syngas into methanol, may be converted to gasoline, olefins, or aromatics. Syngas may be converted to methanol using a copper or zinc catalyst such as a modified ZSM-5 catalyst.

[0007] High temperature solid-oxide fuel cells may be used to produce electricity and water from hydrogen and oxygen (O₂). When run in reverse, the solid-oxide fuel cells are called solid-oxide electrolysis cells and are able to electrolytically reduce and split water into hydrogen and oxygen and carbon dioxide into carbon monoxide and oxygen. The water may be converted into hydrogen, which may be combined with car-

bon monoxide to form syngas. In a solid-oxide electrolysis cell, the anode is the reducing gas electrode and the cathode is the oxidant-side electrode. When operated in reverse, as a solid-oxide electrolysis cell, the anode is the oxidant-side electrode and the cathode is the reducing electrode. Furthermore the solid-oxide electrolysis cell may be used to co-electrolyze a mixture of water and carbon dioxide to produce syngas.

[0008] Improvements to systems and processes for producing syngas are continually sought after by various industries. It would be beneficial to develop efficient systems and methods of producing syngas while minimizing carbon emissions.

BRIEF SUMMARY OF THE INVENTION

[0009] Various embodiments of the present invention include methods and systems for producing hydrogen or syngas by employing thermochemical conversion of a carbonaceous fuel to produce heat to support one or more solid-oxide electrolysis cells. By utilizing heat produced during the thermochemical conversion of the carbonaceous fuel, an external heat source is not needed in the methods and systems. According to various embodiments, configurations of the systems may utilize one or more solid-oxide electrolysis cells that are integrated with the gasification system to utilize high temperature energy available from the gasifier to provide part of the energy required to reduce water to hydrogen and oxygen and carbon dioxide to carbon monoxide and oxygen. A portion of the oxygen produced by reducing water and carbon dioxide may be directed to the thermochemical conversion of the carbonaceous fuel to control the ratio of carbon dioxide to carbon monoxide produced therein. Additionally, various embodiments may employ a counter-flow heat exchange device, or other suitable heat transfer device, to transfer heat produced during thermochemical partial oxidation of the carbonaceous fuel to water or carbon dioxide for electrolysis. Conventionally, an external heat source is employed in the production of syngas. The present invention enables the heat produced during the oxidation of the carbonaceous fuel to be used in the production of syngas. Therefore, a means of producing hydrogen as well as syngas in the absence of an external heat source is provided.

[0010] In accordance with one embodiment of the present invention, a method is provided for producing syngas. The method includes thermochemically converting a carbonaceous fuel to produce a heated mixed gas. The mixed gas may include water, hydrogen, carbon monoxide and carbon dioxide. Steam may be produced by transferring heat from the heated mixed gas produced by the thermochemical conversion of the carbonaceous fuel. Utilizing the heat from the mixed gases produced by the thermochemical conversion process eliminates the need for an external heat source. The steam may be introduced to at least one solid-oxide electrolysis cell and may be decomposed to produce hydrogen and oxygen. The hydrogen produced by electrolysis of steam may be combined with the mixed gas from the gasifier to produce additional syngas. The thermochemical conversion of the carbonaceous fuel may be performed in the presence of a portion of the oxygen produced by electrolysis of steam to control the ratio of carbon dioxide to carbon monoxide in the mixed gas. By augmenting the thermochemical conversion process using oxygen produced by transferring heat from in the mixed gas produced during thermochemical conversion of the carbonaceous fuel, carbon may be used more efficiently. For example, the method may involve re-circulating a

sufficient amount of oxygen produced by the at least one solid-oxide electrolysis cell such that the method is substantially carbon-neutral.

[0011] In accordance with another embodiment of the present invention, a method is provided for forming syngas. The method includes producing heat and a mixed gas by gasifying a carbonaceous fuel, such as biomass. The mixed gas may contain, among other constituents, carbon monoxide, carbon dioxide, water, and hydrogen. Impurities may be removed from the mixed gas to generate a feed stream. For example, the removal of impurities from the mixed gas may be performed by employing a quenching process to condense impurities, such as tar and oils, out of the mixed gas. The heat produced by gasifying the carbonaceous fuel may be transferred to the feed stream to convert at least a portion of the water in the feed stream to steam. The steam may be introduced to at least one solid-oxide electrolysis cell. The carbon dioxide and steam in the feed stream may be electrolyzed in the least one solid-oxide electrolysis cell to produce carbon monoxide, hydrogen and oxygen. The carbon monoxide and hydrogen may be separated from the oxygen to form syngas. By way of non-limiting example, a portion of the hydrogen gas may be used to perform a hydrogen addition reaction to increase the ratio of hydrogen to carbon in a hydrocarbon fuel. A portion of the oxygen may be recirculated to and introduced into the gasifier to control the ratio of carbon dioxide and carbon monoxide in the mixed gas.

[0012] In accordance with a further embodiment of the present invention, a process for forming syngas is provided. The method includes thermochemically converting a carbonaceous fuel to produce heat and a mixed gas. The mixed gas may include carbon dioxide, carbon monoxide, hydrogen and water. The heat produced by the thermochemical conversion may be transferred to a water stream to produce steam. The steam may be electrolyzed to produce hydrogen and oxygen. Also a portion of the carbon dioxide recovered from the mixed gas may be co-electrolyzed with water to produce carbon monoxide and hydrogen. The mixed gas may be cooled and water may be removed from the mixed gas to form syngas.

[0013] In accordance with a further embodiment of the present invention, a process for forming syngas is provided. The method includes thermochemically converting a carbonaceous fuel to produce heat and a mixed gas. The mixed gas may include carbon dioxide, carbon monoxide, hydrogen and water. The heat produced by the thermochemical conversion may be transferred to a water stream to produce steam. The steam may be electrolyzed to produce hydrogen and oxygen. In accordance with this embodiment oxygen produced from the electrolysis cell may replace oxygen supplied to the process from external sources. At least a portion of the oxygen produced by electrolyzing steam is used to control the amount of oxidation during the thermochemical conversion of the carbonaceous fuel. This controlled oxidation will control the ratio of carbon dioxide to carbon monoxide produced when gasifying the carbonaceous fuel. At least a portion of the carbon dioxide and hydrogen in the mixed gas may be converted to carbon monoxide and water using, for example, a water shift reaction. The mixed gas may be cooled and water may be removed from the mixed gas to form syngas.

[0014] In accordance with a further embodiment of the present invention, a method for producing hydrogen gas is provided. The method includes gasifying a carbonaceous fuel to produce a mixed gas. The mixed gas may include carbon

monoxide, carbon dioxide, hydrogen, water, and high-temperature steam. At least a portion of the high-temperature steam may be removed from the mixed gas. The at least a portion of the high-temperature stream may be electrolyzed in at least one solid-oxide electrolysis cell to form hydrogen and oxygen. At least a portion of the carbon monoxide and water in the mixed gas may be converted to hydrogen, carbon dioxide and oxygen. The oxygen may be directed to the gasification process to control the amount of oxidation so that a desired ratio of carbon dioxide to carbon monoxide may be produced. At least one impurity may be removed from the mixed gas. By way of non-limiting example, the hydrogen gas may be combined with carbon monoxide to form syngas. Alternatively, the hydrogen gas may be used in a hydrogen addition reaction to increase the ratio of hydrogen to carbon in hydrocarbon fuels.

[0015] In accordance with yet another embodiment of the present invention, a system is provided for producing syngas. The system includes an apparatus configured to thermochemically convert a carbonaceous fuel into heat and a mixed gas that may include carbon dioxide, carbon monoxide, hydrogen and water, a heat exchange device configured to transfer the heat produced during the conversion of the carbonaceous fuel to at least one of the carbon dioxide and water and at least one solid-oxide electrolysis cell operably coupled to at least one power source and configured to electrolyze at least one of water and carbon dioxide to form oxygen and at least one of hydrogen and carbon monoxide. The oxygen may be recirculated to the apparatus so that the ratio of carbon dioxide to carbon monoxide in the mixed gas may be controlled. For example, the ratio of carbon dioxide to carbon monoxide may be controlled so that the end product includes a desired molar ratio of hydrogen to carbon monoxide. The system utilizes heat in the mixed gas produced by the apparatus during the thermochemical conversion of the carbonaceous fuel to perform electrolysis or co-electrolysis and, thus, only electricity may be provided by an external source. Moreover, the location of the system is not dependent on the location of an external heat source.

BRIEF DESCRIPTION OF THE SEVERAL VIEWS OF THE DRAWINGS

[0016] FIGS. 1 and 2 are schematic diagrams illustrating embodiments of syngas production processes; and

[0017] FIGS. 3-6 are schematic diagrams depicting various embodiments of systems for producing syngas.

DETAILED DESCRIPTION OF THE INVENTION

[0018] Various embodiments of the present invention provide methods and systems for forming syngas by combining a thermochemical conversion process of a carbonaceous fuel with an electrolytic process. As used herein, the term “thermochemical conversion process” means and includes combustion, gasification, or pyrolyzation of the carbonaceous fuel. For convenience, the term “thermochemical conversion process,” or grammatical equivalents thereof, is used to collectively refer to a combustion process, a gasification process, or a pyrolyzation process, while the terms “combustion,” “gasification,” or “pyrolyzation,” or grammatical equivalents thereof, are used herein to refer to a specific type of thermochemical conversion process. The term “electrolytic process” means and includes a high temperature electrolysis or a co-electrolysis process. The term “high temperature electrolysis

process” is used to refer to the electrolytic decomposition of water into hydrogen and oxygen at a temperature above 500° C., while the term “co-electrolysis process” is used to refer to the simultaneous electrolytic decomposition of water into hydrogen and oxygen and carbon dioxide into carbon monoxide and oxygen. For convenience, the term “electrolytic process” is used to collectively refer to the terms “high temperature electrolysis process” and “co-electrolysis process.” The term “carbonaceous fuel,” as used herein, means and includes a solid, liquid, or gas form of a combustible material composed of carbon-containing compounds. By way of example only, the carbonaceous fuel may be a biomass source composed primarily of vegetative matter, such as corn stover, wheat straw, barley straw, tree bark, wood waste, cellulose, bagasse, municipal wastes and combinations thereof. Additionally, the carbonaceous fuel may include a fossil fuel. By way of non-limiting example, the fossil fuel may be coal, such as brown coal, peat, wood, coke, soot, and combinations thereof, or a liquid fuel, such as tar sand oil, shale oil, and combinations thereof. The carbonaceous fuel may include combinations of any of the carbon-containing compounds mentioned above. The syngas produced from the carbonaceous fuel may be converted to synfuel using a process known in the art such as, for example, a Fischer-Tropsch process. Hydrogen and/or carbon monoxide produced from high temperature electrolysis of steam or carbon dioxide may be integrated with the thermochemical conversion of a carbonaceous fuel to produce hydrogen or syngas. By utilizing the carbonaceous fuel as a heat source to support the electrolytic process, syngas production may be performed at locations that are remote from an industrial process heat source, such as a nuclear power plant or solar concentrator. Oxygen produced from high temperature electrolysis of steam or carbon dioxide may be used to augment oxygen from an air separation unit or other oxygen enriching process or may replace such devices to produce all of the oxygen required to support production of hydrogen or syngas from a carbonaceous fuel.

[0019] The methods and systems described herein may be adapted for use in large, medium or small scale process operations. According to embodiments, syngas may be produced utilizing heat from the combustion of a carbonaceous fuel to support at least one solid-oxide electrolysis cell operably coupled to receive electricity generated from at least one power source. The methods and systems may further include a Fischer-Tropsch process to effectively convert the syngas to a synfuel. By way of non-limiting example, the methods and systems may be varied to produce a syngas with a desired ratio of constituents, more specifically, a molar ratio of hydrogen (H_2) to carbon monoxide (CO) of about 2.12:1. If a cobalt catalyst is used to perform the Fischer-Tropsch, the hydrogen to carbon monoxide molar ratio may be in a range of from about 2.0:1 to about 2.12:1. If an iron catalyst is used in the Fischer-Tropsch process, a hydrogen to carbon monoxide molar ratio may be in a range of from about 0.8:1 to about 1.8:1. The molar ratio of hydrogen to carbon monoxide may be varied dependent on reactor used in the thermochemical conversion apparatus, the process configuration or catalyst used to conduct the Fischer-Tropsch reaction.

[0020] As will be described in further detail hereinbelow, embodiments of the present invention may include a combination of heat exchangers, separation valves and reactors that may be employed in forming syngas while minimizing the release of carbon dioxide. The methods and systems for pro-

ducing syngas by incorporating thermochemical conversion of a carbonaceous fuel with the electrolysis process may be configured to be a substantially carbon-neutral process. As used herein, the term “carbon-neutral” means and includes processing in which an amount of carbon, in the form of carbon dioxide, released is equal to the amount of the carbon in the carbon input. Additionally, “carbon-neutral” means and includes processing in which substantially all of the carbon input is used to form carbon output with substantially no carbon dioxide release. By completely recycling and co-electrolyzing the carbon dioxide in using the solid-oxide fuel cells to produce syngas for subsequent use in product formation, (i.e., zero) total carbon release may be achieved.

[0021] FIG. 1 is a simplified schematic of an embodiment of a hydrocarbon production process 100 that utilizes heat produced by the combustion of a carbonaceous fuel to support an electrolytic process 114. The hydrocarbon production processes 100 may include sub-processes, such as a thermochemical conversion process 106, the electrolytic process 114, a power generation process 116, a heat exchange process 124, a Fischer-Tropsch process 135, and, optionally, a water shift process (not shown), a water knockout process (not shown), and a gas cleanup process (not shown). The sub-processes of the hydrocarbon production process 100 are illustrated as sub-process blocks in FIG. 1.

[0022] By way of non-limiting example, thermochemical conversion process 106 may be employed to convert an input 102 including the carbonaceous fuel to a product stream 110 that may include a mixed gas. As used herein, the term “mixed gas” means and includes a gaseous or substantially gaseous fluid having multiple components or constituents produced by the thermal conversion of the input 102. For example, a gasification process or a combustion process may be used as the thermochemical conversion process and the resulting mixed gas may include water, hydrogen, carbon dioxide, and carbon monoxide. Alternatively, a pyrolyzation process may be used as the thermochemical conversion process and the mixed gas may include water, hydrogen, carbon dioxide, carbon monoxide and methane (CH_4). Other components may be produced during the thermochemical conversion process as will be appreciated by those of ordinary skill in the art.

[0023] The input 102 may be thermochemically converted to the product stream 110 using a process such as gasification, combustion, or pyrolysis. In some embodiments, gasification may be employed as the thermochemical conversion process 106 to form the product stream 110 by introducing an oxidizing gas, such as oxygen or water, into a gasifier with the input 102 at high temperatures. The gasification process controls how much oxygen is burned with the carbonaceous fuel. The amount of oxygen introduced into the gasifier may be adjusted to vary the ratio of carbon dioxide to carbon monoxide produced by gasification of the carbonaceous fuel. By limiting or controlling the amount of oxygen introduced into the gasification process, the amount of carbon monoxide produced may be increased while the amount of carbon dioxide may be decreased. The gasification may be conducted in a conventional gasifier. Types of gasifiers known in the art, such as an updraft gasifier, a downdraft gasifier and a fluidized bed gasifier, may be used to convert the carbonaceous fuel to the product stream 110. In some embodiments, hydrogen or steam may be injected into the gasifier during gasification to suppress formation of carbon dioxide, thus, resulting in an increase in the ratio of carbon monoxide to carbon dioxide. The gasifier may be indirectly heated by transferring heat

from a source, such as a combustor, a chemically regenerative heat carrier, or a heat storage phase-change material. Gasification of the carbonaceous fuel may be performed at temperatures in a range of from about 1400° C. to about 1600° C. In some embodiments, the product stream **110** formed by gasification of the carbonaceous fuel may include, for example, carbon monoxide, hydrogen, carbon dioxide and water.

[0024] In some embodiments, combustion may be used as the thermochemical conversion process **106** to convert the carbonaceous fuel in the input **102** to the product stream **110**, which may include carbon dioxide, carbon monoxide, hydrogen, water and other components. During the combustion, oxygen may be introduced into a combustion chamber, where the oxygen reacts with, and at least partially oxidizes, the carbonaceous fuel to form the product stream **110** and heat. As the amount of oxygen used to combust the carbonaceous fuel is not controlled, the resulting product stream **110** may include a high ratio of carbon dioxide to carbon monoxide. The combustion may be conducted in a conventional combustion chamber.

[0025] In additional embodiments, the carbonaceous fuel in the input **102** may be thermochemically converted in the absence of oxygen using pyrolysis as the thermochemical conversion process **106**. The pyrolysis may be conducted in a conventional pyrolyzer. Types of pyrolyzers known in the art include, but are not limited to, a bubbling fluid bed, a circulating and transported bed, a cyclonic reactor, and an ablative reactor. Pyrolysis may be performed by heating the bed or reactor with a heat source (not shown). Heat sources may include, but are not limited to, combustion or gasification of a carbonaceous fuel, or electrical or nuclear process heat. The bed or reactor may operate at temperatures less than or equal to about 700° C.

[0026] After formation by the thermochemical conversion process **106**, the product stream **110** may be processed, for example, using a quenching process (not shown), a water shift process (not shown), a water knockout process (not shown), and a gas cleanup process (not shown). In some embodiments, such processes may be used to alter the constituents of the product stream **110**. Additionally, impurities incorporated into the product stream **110** during formation, such as tars and oils, may be removed from the product stream **110**. As a non-limiting example, a quenching process (not shown) may be utilized to condense at least one impurity to remove the impurity from the product stream **110** such that components thereof, such as water, are suitable for electrolysis.

[0027] The product stream **110** may undergo a heat exchange process **124** to increase the temperature of at least one component in the mixed gas of the product stream **110** to facilitate the electrolytic process **114**. By way of non-limiting example, the heat exchange process **124** may be performed using a counter-flow heat exchanger, such as a recuperator, a phase-change heat exchanger, a fluid heat exchanger, a plate heat exchanger, a regenerative heat exchanger, or any other device known in the art for exchanging heat between gas and fluid streams. The heat exchange process **124** may be used, for example, to convert water in the product stream **110** to steam. The heat exchange process **124** may be used to transfer heat from produced during the thermochemical conversion process **106** to components of the product stream **110** that will be electrolyzed. By transferring the heat produced during the thermochemical conversion process **106** to gases fed into the electrolytic process **114**, an external heat source is not

needed and the hydrocarbon production process **100** does not need to be co-located with an external heat source.

[0028] In some embodiments, the constitution of the product stream **110** may be altered by electrolyzing at least one of the components of the product stream **110** using the electrolytic process **114**. The electrolytic process **114** may employ at least one solid oxide electrolysis cell to electrolyze the components, such as water and carbon dioxide, in the product stream **110**. In additional embodiments, the product stream **110** may be altered using, for example, the water shift process or the water knockout process, to form product stream **110'** that may be combined with hydrogen stream **112** produced by the electrolytic process **114**.

[0029] The hydrocarbon production process **100** may further include a power generation process **116** for supplying electrical energy to the electrolytic process **114**. For example, the power generation process **116** may include a direct current power source, such as an electric outlet connected to a commercial power grid, a generator powered by gas, electricity, wind, water, steam, nuclear energy, solar energy, or other energy source, a battery or battery array, or any other conventional power source capable of supplying an electrical current to the electrolytic process **114**. A renewable power source may be employed as the power generation process **116** such that the hydrocarbon production process **100** may be configured to be substantially carbon-neutral. For example, the electrolytic process **114** may be located in proximity to a nuclear energy source such that electricity is readily available. Additionally, the electrolytic process **114** may be located in proximity to a conventional power plant such that steam and heat produced by the power plant may be used with the processes according to embodiments of the invention.

[0030] A single solid-oxide electrolysis cell or an array of such cells may be used to perform the electrolytic process **114**. The solid-oxide electrolysis cell may include a cathode, an anode, and an electrolyte sandwiched or otherwise positioned between the cathode and anode. An electrical current may be provided to the anode and the cathode of the solid-oxide electrolysis cell by the power generation process **116**.

[0031] During co-electrolysis, carbon dioxide (CO₂) and steam (H₂O) from the product stream **110** may be introduced on the cathode side of the solid-oxide electrolysis cell. The CO₂ and the H₂O may be simultaneously electrolyzed. These components of the product stream **110** may undergo electrolysis, forming two product streams: an oxygen stream **104** and a syngas stream **140**. The steam, or water, decomposes in the presence of electrons supplied to the cathode by the power generation process **116** according to Reaction 2:



The decomposition of water in the cathode produces hydrogen (H₂) and oxygen ions (O²⁻). The oxygen ions may pass through the electrolyte to the anode, where the oxygen ions give up electrons, forming oxygen (O₂) which exits the electrolytic process **114** as oxygen stream **104**. Hydrogen formed by the decomposition of water in the cathode may not pass through the electrolyte and may be collected. The oxygen stream **104** may pass through the solid-oxide electrolysis cell, exiting the anode of the solid-oxide electrolysis cell.

[0032] Carbon dioxide introduced on the cathode side of the solid-oxide electrolysis cell may undergo a similar electrolytic reaction as the steam, wherein the carbon dioxide

decomposes in the presence of electrons supplied to the cathode by the power generation process **116** according to Reaction 3a:



The carbon dioxide introduced to the cathode may also react with the hydrogen produced in the solid-oxide electrolysis cell to form carbon monoxide and water, for example, according to Reaction 3b:



The carbon monoxide may combine with the hydrogen to form the syngas stream **140**. The water by-product of the reaction of carbon dioxide with hydrogen may be decomposed according to Reaction 2 or portions of the water may be carried away. The syngas stream **140** may comprise components of syngas—carbon monoxide and hydrogen—which may exit the cathode of the solid-oxide electrolysis cell. The hydrogen stream **112** may be fed to a synfuels production process or may be stored as syngas.

[0033] Alternatively, high temperature electrolysis may be performed by introducing water or steam **111** on the cathode side of the solid-oxide electrolysis cell. Steam **111** may be formed by heating a water stream **120**, such as boiler feed water, using the heat exchange process **124**. Specifically, the heat from the product stream **110** produced during the thermochemical conversion process **106** may be captured and transferred to the water stream **120** using the heat exchange process **124**. The transfer of heat from the product stream **110** to the water stream **120** to form steam **111** eliminates the need for a heat source other than the thermochemical conversion process **106**. Therefore, the hydrocarbon production process **100** may be located remote from an industrial heat source. The steam **111** may undergo high temperature electrolysis using the electrolytic process **114** to form an oxygen stream **104** and a hydrogen stream **112**. The high temperature electrolysis of carbon dioxide and steam into carbon monoxide and hydrogen may be performed at temperatures between about 500° C. and about 1200° C. In some particular embodiments, the high temperature electrolysis may be performed at a temperature between about 800° C. and 1000° C. The oxygen stream **104** may pass through the solid-oxide electrolysis cell, exiting the anode of the solid-oxide electrolysis cell. The hydrogen stream **112** may exit the cathode side of the solid-oxide electrolysis cell.

[0034] A conventional water shift process and a conventional water knockout process may be employed to alter the constituents of the product stream **110** such that product stream **110'** contains a suitable ratio of hydrogen to carbon monoxide. The water shift process involves an inorganic chemical reaction in which water and carbon monoxide react to form carbon dioxide and hydrogen. The water shift process may be performed in reverse using a catalyst, such as a copper/silicon dioxide or copper/alumina, to convert carbon dioxide and hydrogen in the product stream **110** to carbon monoxide and water, forming the product stream **110'** with an increased ratio of carbon monoxide and water. The product stream **110'** as altered by processes such as the water shift process and the water knockout process may be combined with the hydrogen stream **112** to form syngas **140**. By adapting the process **100**, as will be described in further detail below, the ratio of hydrogen to carbon monoxide in the syngas **140** may be controlled. By way of non-limiting example, the

process **100** may be configured such that the syngas includes a ratio of hydrogen to carbon monoxide in the range of 1.7:1 to 2.12:1.

[0035] Specifically, the ratio of hydrogen to carbon monoxide in the syngas **140** may be controlled using a variety of means. By way of non-limiting example, the thermochemical conversion process **106** is a gasification process or a combustion process, the oxygen stream **104** may be re-circulated to the thermochemical conversion process **106**. In the gasification process, the recirculation of the oxygen stream may be altered to control the level of oxidation occurring during the gasification process so that the ratio of carbon dioxide to carbon monoxide in the product stream **110** may be controlled within a desired ratio. By controlling the ratio of carbon dioxide to carbon monoxide in the product stream, the ratio of hydrogen to carbon monoxide in the syngas **140** may ultimately be controlled.

[0036] The syngas **140** may be fed to an apparatus or reactor suitable for conducting a Fischer-Tropsch process **135** to convert the hydrogen and carbon monoxide in the syngas **140** to a synthetic liquid fuel, or synfuel **155**. For example, to conduct the Fischer-Tropsch process **135**, the syngas **140** may be discharged into a conventional Fischer-Tropsch reactor. In the Fischer-Tropsch reactor, the syngas **140** may be contacted with a catalyst to convert a portion of the syngas **140** into synfuel **155**. The synfuel **155** may be readily captured and stored in a suitable container (not shown), such as a storage pile or storage tank. Alternatively, the syngas may be converted to methanol by way of a copper- or zinc-containing catalyst. Methanol may be used to form gasoline and olefins by conventional processing.

[0037] FIG. 2 is a simplified schematic of an embodiment of a hydrocarbon production process **200** that utilizes a gasification process **206** as the thermochemical conversion process **106**. The hydrocarbon production process **200** may include sub-processes such as a gasification process **206**, an electrolytic process **114**, power generation process **116**, a heat exchange process (not shown), a water shift process **132**, a gas cleanup process **202**, a recovery process **204**, a Fischer-Tropsch process **135**, and a mixing process **212**. The sub-processes of the hydrocarbon production process **200** are illustrated as sub-process blocks in FIG. 2.

[0038] An input **102** including at least one carbonaceous fuel may be gasified to form a product stream **210** including a mixed gas and high-temperature steam **218** using the gasification process **206**. The mixed gas of the product stream **210** may include, for example, water, hydrogen, carbon dioxide, and carbon monoxide as well as non-hydrocarbon contaminants. As used herein, the term “non-hydrocarbon contaminants” means and includes contaminants, such as hydrogen sulfide, carbon dioxide, nitrogen and water, which are typically produced by gasification of carbonaceous fuels.

[0039] A water supply **216** and an oxygen stream **104** may be used to facilitate the gasification process **206**. The oxygen stream **104** may be re-circulated from within the hydrocarbon production process **200**, as will be described below, or may be obtained from an air supply unit (not shown). The heat produced during the gasification process **206** may be used to heat water or steam, for example, in a quenching process (not shown) forming high temperature steam **218**. By way of non-limiting example, a radiant syngas cooler may be employed in the quenching process and may be internal or external to the gasifier. The high-temperature steam **218** exiting the quenching process may be electrolyzed to form an

oxygen stream **104** and a hydrogen stream **112** by employing an electrolytic process **114**. The oxygen stream **104** may be cycled to, and utilized in, the gasification process **206**. Recirculation of the oxygen stream **104** to the gasification process **206** enables the amount of oxidation occurring during the gasification process **206** to be controlled and, thus enables the ratio of carbon dioxide to carbon monoxide to be controlled in the product stream **210**.

[0040] Where the product stream **210** produced by the gasification of the input **102** has a hydrogen to carbon monoxide ratio too low for conversion to synfuels by a Fischer Tropsch reaction, the water shift process **132** may be employed to convert carbon monoxide and water in the product stream **210** to carbon dioxide and hydrogen, forming product stream **210'** with an increased ratio of hydrogen to carbon monoxide. For example, the hydrogen to carbon dioxide ratio in the product stream **210'** may be about 2.12:1. A gas cleanup process **202** may be used to remove carbon dioxide and hydrogen sulfide from the product stream **210'**.

[0041] After removal of carbon dioxide and hydrogen sulfide, product stream **210''** may include carbon monoxide, hydrogen, water, and steam as well as non-hydrocarbon contaminants produced during the gasification process **206**. The carbon monoxide and hydrogen in the product stream **210''** may be converted to synfuel **155** using the Fischer-Tropsch process **135**. The synfuel **155** may be fed to a recovery process **204** to separate light hydrocarbons **208**, wax hydrocarbons **211** and hydrogen **112'** from the synfuel **155** using, for example, a palladium alloy catalyst. As used herein, the term "light hydrocarbon" means and includes a hydrocarbon having a low molecular weight such as methane, ethane, propane and butane. The term "wax hydrocarbon," as used herein, means and includes a hydrocarbon such as naphthenic compounds (i.e., naphthenes, cycloparaffins or hydrogenated benzenes), paraffinic compounds and olefinic compounds typically having a molecular weight of greater than about 450 amu.

[0042] As a non-limiting example, the light hydrocarbons **208** removed from the synfuel **115** may be used in power generation. The hydrogen stream **112'** removed during the recovery process **204** and the hydrogen stream **112** produced by the electrolytic process **114** may be combined with the wax hydrocarbons **211** using a mixing process **212** to form a liquid fuel **214**. As used herein, the term "liquid fuel" means and includes liquid hydrocarbon compounds such as propanes, butanes, pentanes and heavier hydrocarbon products.

[0043] Referring to FIG. 3, a process diagram is shown for a syngas production system **300** in accordance with an embodiment of the invention. The process diagram includes a variety of flow paths associated with different acts of the process for syngas production as will be described in detail below. An input **102** including a carbonaceous fuel such as, for example, a biomass source, may be fed into a thermochemical conversion apparatus **406**, such as a gasifier, a pyrolyzer or a combustor. As a non-limiting example, the carbonaceous fuel may be cellulose. Solid carbonaceous fuel may be pulverized to facilitate transport into the thermochemical conversion apparatus **406**. In some embodiments, process heat **408** may be used to facilitate the gasification of the carbonaceous fuel in the input **102**.

[0044] In some embodiments, a gasifier may be employed as the thermochemical conversion apparatus **406** and the input **102** may be fed into the gasifier with an oxygen stream **104** to produce a desired ratio carbon monoxide to carbon

dioxide in the product stream **310**. The oxygen stream **104** may be produced and recycled from within the syngas production system **300** as will be described in detail below. In embodiments using a gasifier as the thermochemical conversion apparatus **406**, the oxygen stream **104** injected into the gasifier may be controlled to produce a desired ratio of carbon monoxide to carbon dioxide in the product stream **310**. In embodiments using a pyrolyzer as the thermochemical conversion apparatus **406**, the oxygen stream **104** may not be utilized. Thermochemical conversion of the carbonaceous fuel in the input **102**, optionally in the presence of oxygen, creates a product stream **310** that may include, for example, water, hydrogen, carbon dioxide, and carbon monoxide, as well as other constituents or components as will be appreciated by those of ordinary skill in the art. As a non-limiting example, the product stream **310** may include from about 18% by volume to about 38% by volume water, from about 8% by volume to about 28% by volume hydrogen, from about 8% by volume to about 28% by volume carbon dioxide, and from about 27% by volume to about 47% by volume carbon monoxide. The product stream **310** may exit the thermochemical conversion apparatus **406** at a temperature in a range of from about 1300° C. to about 1450° C.

[0045] The product stream **310** may be directed to and mixed with a portion **112'** of a hydrogen stream **112** by way of a mixing valve **413a**, or other suitable piping configuration or device, to form a product stream **310'**. The portion **112'** of the hydrogen stream **112** may be directed from a valve **428a** after being produced by decomposition of steam **218** using a solid-oxide electrolysis cell array **414**, which may include one or more solid-oxide electrolysis cells, as described in detail below.

[0046] A water stream **420** may be pumped into the syngas production system **300** using an apparatus such as a water pump **422**. Upon entering the syngas production system **300**, the water stream **420** may have a temperature in the range of from about 11° C. to about 31° C. As a non-limiting example, the water pump **422** may be operated using energy obtained from a renewable source, such as nuclear power, hydro power or wind power. The water stream **420** may be pumped into a heat exchanger, such as a recuperator **424**, or any other device known in the art for exchanging heat between gas and fluid streams. The heat from the recuperator **424** may vaporize at least part of the water stream **420** to form high-temperature steam **218**. Because the heat in the mixed gas produced by the thermochemical conversion apparatus **406** is used to vaporize water for electrolysis, the syngas production system **300** may not be dependent and, thus may not be located within the vicinity of, an external heat source (not shown).

[0047] After exiting the recuperator **424**, the high-temperature steam **218** may have a temperature in the range of from about 770° C. to about 980° C. The high-temperature steam **218** formed by passing the water stream **420** through the recuperator **424** may be fed through another valve **413b** and combined with another portion **112''** of the hydrogen stream **112** to form a feed stream **426** that includes steam and hydrogen. The feed stream **426** may include less than or equal to about 5% by volume water and greater than or equal to about 95% by volume hydrogen and may have a temperature in a range of from about 681° C. to about 881° C.

[0048] The feed stream **426** may be fed into the solid-oxide electrolysis cell array **414**. Solid-oxide electrolysis cells in the solid-oxide electrolysis cell array **414** may be employed to decompose steam in the feed stream **426** to form a hydrogen

stream 112 and an oxygen stream 104. A power source 416, such as a conventional renewable power source, may be used to provide an electrical current to the solid-oxide electrolysis cell array 414. For example, the power source 416 may provide an electrical current to the solid-oxide electrolysis cell array 414. Additionally, a heat source 418 may be provided to the solid-oxide electrolysis cell array 414 as necessary to support electrolysis of the steam. The heat source 418 may originate from the thermochemical conversion apparatus 406.

[0049] The oxygen stream 104 may be directed to and cooled by the recuperator 424, and additionally, may further be cooled by an ambient cooler 427. For example, the oxygen stream 104 may be cooled to a temperature of from about 17° C. to about 27° C. The cooled oxygen stream 104 may be split using another valve 428b or any other apparatus suitable for splitting the oxygen stream 104, such that a desired amount of the oxygen stream 104 is cycled to and fed into the thermochemical conversion apparatus 406 to control the amount of oxidation and the remaining excess oxygen 430 is discharged from the syngas production system 300. By controlling the amount of oxidation occurring during the thermochemical conversion of the carbonaceous fuel, the ratio of carbon dioxide to carbon monoxide may be advantageously controlled.

[0050] The hydrogen stream 112 produced by the solid-oxide electrolysis cell array 414 may additionally include water or steam and may be directed to valve 428a, or any other suitable device suitable for splitting the hydrogen stream 112, such that a portion 112' of hydrogen stream 112 may be fed into the mixing valve 413a and combined with the product stream 310 to form a product stream 310' including an increased amount of hydrogen and steam. Another portion 112" of the hydrogen stream 112 may be fed into another mixing valve 413b to be combined with high-temperature steam 218 directed from the recuperator 424 to form the feed stream 426. The product stream 310' may include from about 5% to about 25% by volume water, from about 46% to about 66% by volume hydrogen, from about 0.01% to about 5% by volume carbon dioxide, and from about 9% to about 20% by volume carbon monoxide. The product stream 310' may have a temperature in a range of from about 1050° C. to about 1165° C.

[0051] The product stream 310' may be fed into a conventional water shift reactor 432 that may include, for example, a copper or iron-based catalyst. The water shift reactor 432 may convert carbon dioxide and hydrogen in the product stream 310' to carbon monoxide and water, resulting in a product stream 310" having substantially increased amounts of carbon monoxide and water. As a non-limiting example, the product stream 310" may include hydrogen and carbon dioxide in a ratio of about 2.12:1. Upon exiting the water shift reactor 432, a product stream 310" may include from about 10% to about 30% by volume water, from about 41% to about 61% by volume hydrogen, from about 0.01% to about 14% by volume carbon dioxide, and from about 14% to about 34% by volume carbon monoxide. The product stream 310" may have a temperature in the range of from about 1023° C. to about 1123° C.

[0052] The product stream 310" may be passed through and cooled by the recuperator 424, thus retaining process heat created during gasification of the carbonaceous fuel in the input 102. As such, the process heat in the product stream 310" produced during the thermochemical conversion of the carbonaceous fuel may be transferred to form high-temperature steam 218 and, thus, is used to support the formation of

hydrogen and oxygen by the solid-oxide electrolysis cell array 414. After cooling by the recuperator 424, the product stream 310" may be flowed to a separation tank, such as a conventional water knockout tank 436 or any other device configured to remove water from the product stream 310". By removing excess water 438 from the product stream 310", a syngas 140 is formed that is substantially free of water. The syngas 140 may include, for example, hydrogen and carbon monoxide. By way of non-limiting example, the syngas 140 may include less than about 5% water, from about 54% to about 74% hydrogen, less than about 16% carbon dioxide, and from about 20% to about 40% carbon monoxide. Conventional ambient cooling 434 may be used to facilitate removal of water 438 by the water knockout tank 436.

[0053] Referring to FIG. 4, a process diagram is shown for a syngas production system 400 in accordance with an embodiment of the invention. The syngas production system 400 includes a variety of flow paths associated with different acts of the process, as will be described in detail below. An input 102 including a carbonaceous fuel such as, for example, a biomass source, may be fed into a thermochemical conversion apparatus 406. By way of non-limiting example, the thermochemical conversion apparatus 406 may be a gasifier, a combustor or a pyrolyzer. In embodiments employing a gasifier or a combustor as the thermochemical conversion apparatus 406, the thermochemical conversion apparatus 406 may be supplied with an oxygen stream 104 and a portion 112' of the hydrogen stream 112. Optionally, the thermochemical conversion apparatus 406 may be operated in the presence of process heat 408 to gasify the carbonaceous fuel in the input 102. As a non-limiting example, the input 102 may include pulverized cellulose.

[0054] The input 102 may be fed into the thermochemical conversion apparatus 406 with an oxygen stream 104 and portion 112' of the hydrogen stream 112. The oxygen stream 104 and the portion 112' of the hydrogen stream 112 may be produced and recycled from within the syngas production system 400, as will be described in greater detail below. Thermochemical conversion of the carbonaceous fuel in the presence of the oxygen stream 104 and the portion 112' of the hydrogen stream 112, creates a product stream 410 that may include, for example, water, hydrogen, carbon dioxide, carbon monoxide, and methane, as well as other constituents or components as will be appreciated by those of ordinary skill in the art. The product stream 410 may include from about 12% to about 32% by volume water, from about 40% to about 60% by volume hydrogen, less than about 5% by volume carbon dioxide, from about 14% to about 34% by volume carbon monoxide, and less than about 1% by volume methane. By way of non-limiting example, the product stream 410 may have a temperature in a range of from about 1321° C. to about 1421° C.

[0055] The product stream 410 may be fed into a conventional water shift reactor 432 wherein carbon dioxide and hydrogen in the product stream 410 are converted to carbon monoxide and water. Thus, the product stream 410' exiting the water shift reactor 432 may have a substantially increased amount of carbon monoxide and water. As a non-limiting example, the product stream 410' may have a temperature in a range of from about 1321° C. to about 1421° C. and may include from about 12% to about 32% by volume water, from about 41% to about 61% by volume hydrogen, from about 0.01% to about 8% by volume carbon dioxide, from about

14% to about 34% by volume carbon monoxide, and less than about 0.01% by volume methane.

[0056] The product stream **410'** may be passed through a heat exchanger, such as recuperator **424** or any other device known in the art for exchanging heat between gas and fluid streams, such that the product stream **410'** is substantially cooled and heat generated during the thermochemical conversion of the carbonaceous fuel is recovered. For example, after passing through the recuperator **424**, the product stream **410'** may have a temperature in a range of from about 409° C. to about 509° C. The cooled product stream **410'** may be flowed to a separation tank, such as a conventional water knockout tank **436**, or any other device capable of removing excess water **438** from the product stream **410'**. The water knockout tank **436** removes excess water **438** from the product stream **410'**, forming a syngas **140** that is substantially free of water. The syngas **140** may include, for example, less than about 5% water, from about 55% to about 75% hydrogen, less than about 8% carbon dioxide, from about 21% to about 41% carbon monoxide, and less than about 5% methane. A Fischer-Tropsch process (not shown) may be used to convert the syngas **140** to synfuel which may be used a fuel or stored in a suitable container. Additionally, a catalytic process may be used to convert the syngas **140** into methanol, which may be used in the formation of hydrocarbon products, such as gasoline.

[0057] A water stream **420** may be pumped into the syngas production system **400** using an apparatus such as a water pump **422**. As a non-limiting example, the water stream **420** may enter at a temperature in a range of from about 11° C. to about 31° C. The water stream **420** may be pumped into the recuperator **424**, where heat from the gasification process has been captured and vaporizes the water stream **420** to form high-temperature steam **218**. The high temperature steam **218** exiting the recuperator **424** may have a temperature in a range of from about 780° C. to about 880° C. By transferring heat from the product stream **410'** to the water stream **420** to form high-temperature steam **218**, heat produced during thermochemical conversion of the carbonaceous fuel is used to support the decomposition of water by the solid-oxide electrolysis array **414**. Therefore, the syngas production system **400** is not dependent on an external heat source. Because the syngas production system **400** does not need to be co-localized with the external heat source, the syngas production system **400** provides advantages over conventional syngas production.

[0058] The high-temperature steam **218** formed by the recuperator **424** may be fed into a mixing valve **413a** and combined with another portion **112"** of the hydrogen stream **112** to obtain a feed stream **426** that may include steam and hydrogen, among other components. By way of non-limiting example, the feed stream **426** may include less than or equal to about 5% by volume water and greater than or equal to about 95% by volume hydrogen and may have a temperature in a range of from about 777° C. to about 877° C. The feed stream **426** may be fed into and decomposed by the solid-oxide electrolysis cell array **414** to form a hydrogen stream **112** and an oxygen stream **104**. A power source **416** may be used to provide an electrical current to the solid-oxide electrolysis cell array **414**. For example, the power source **416** may provide an electrical current in a range of from about 2554 kW to about 2624 kW. Additionally, process heat **408** may be provided to the solid-oxide electrolysis cell array **414** as needed to support electrolysis of the high-temperature steam **218**. Heat produced by the thermochemical conversion

apparatus **406** during gasification, combustion or pyrolyzation of the carbonaceous fuel may, optionally, be used as the process heat **408**.

[0059] The oxygen stream **104** produced by the solid-oxide electrolysis cell array **414** may be directed to and cooled by the recuperator **424**. The temperature of the oxygen stream **104** after cooling by the recuperator **424** may be in a range of from about 27° C. to about 137° C. Additionally, the oxygen stream **104** may be further cooled to a temperature in a range of from about 5° C. to about 70° C. using a conventional ambient cooler **427**. Once cooled, the oxygen stream **104** may be split using a valve **428a**, or any other device configured to split the oxygen stream **104**, such that a desired amount of oxygen is cycled to and fed into the gasifier **306** and the remaining excess cooled oxygen **430** may be expelled from the system **400**. The desired amount of oxygen may be fed into the gasifier **306** to control the amount of oxidation occurring therein so that the ratio of carbon dioxide to carbon monoxide may be altered.

[0060] The hydrogen stream **112** produced by the solid-oxide electrolysis cell array **414** may be directed to another valve **428b**, or any other suitable device such that a portion **112'** of the hydrogen stream **112** may be recycled and injected into the thermochemical conversion apparatus **406** and another portion **112"** of the hydrogen stream **112** mixed with high-temperature steam **218** by way of a mixing valve **413a** to form the feed stream **426**.

[0061] Referring to FIG. 5, a process diagram is shown for a syngas production system **500** in accordance with another embodiment of the present invention. The syngas production system **500** includes a variety of flow paths associated with different acts of the process as will be described in detail below. An input **102** including a carbonaceous fuel may be fed into a thermochemical conversion apparatus **406**, such as a gasifier, a combustor or a pyrolyzer. In embodiments employing a combustor or gasifier as the thermochemical conversion apparatus **406**, the input **102** may be introduced with an oxygen stream **104'**. The carbonaceous fuel may be, as a non-limiting example, a biomass source, such as cellulose. Thermochemical conversion of the carbonaceous fuel in the input **102**, optionally in the presence of oxygen, creates a product stream **510** that may include, for example, water, hydrogen, carbon dioxide, carbon monoxide, and methane as well as other constituents or components as will be appreciated by those of ordinary skill in the art. By way of non-limiting example, the product stream **510** may have a temperature in a range of from about 1050° C. to about 1165° C. and may include from about 18% to about 38% by volume water, from about 8% to about 28% by volume hydrogen, from about 8% to about 28% by volume carbon dioxide, and from about 27% to about 47% by volume carbon monoxide.

[0062] The product stream **510** may be cooled by directing the product stream **510** and a portion **420'** of a water stream **420** into a quencher **509**. By way of non-limiting example, the water stream **420** may be introduced into the syngas production system **500** using a water pump **422** and may be split using, for example, a valve **428a** or other suitable device, such that a portion **420'** of the water stream **420** may be directed to the quencher **509** and another portion **420"** of the water stream **420** may be directed to a mixing valve **413a**. The portion **420'** of the water stream **420** may be introduced to the quencher **509** at a substantially lower temperature than that of the product stream **510**. For example, the portion **420'** of the water stream **420** may be introduced into the quencher at a

temperature in a range of from about 5° C. to about 71.5° C. The quenching process may form a product stream **510'** including, as a non-limiting example, from about 86% to about 98% by volume water and less than about 5% by volume of each of hydrogen, carbon dioxide, and carbon monoxide. The quencher **509** may be used to cool the product stream **510** to a temperature at or near the saturation level such that water in the product stream **510** is present in a liquid phase.

[0063] The cooled product stream **510'** may be directed to a separation tank, such as a water knockout tank **436**, to remove excess water **438** formed as a byproduct of thermochemical conversion of the carbonaceous fuel or incorporated during the quenching process. Removal of water from the product stream **510'** may form a product stream **510''** that includes, by way of non-limiting example, less than about 5% by volume water, from about 15% to about 35% by volume hydrogen, from about 12% to about 32% by volume carbon dioxide, and from about 42% to about 62% by volume carbon monoxide.

[0064] After removal of excess water **438**, the product stream **510''** may be combined with another portion **420''** of the water stream **420** using the mixing valve **413a**, or other suitable device. Thus, a product stream **510'''** exiting the mixing valve **413a** includes an increased amount of water. As a non-limiting example, the product stream **510'''** may exhibit a temperature in a range of from about 4.8° C. to about 84.8° C. and may include from about 47% to about 67% by volume water, from about 1% to about 21% by volume hydrogen, from about 0.01% to about 11% by volume carbon dioxide, and from about 13% to about 33% by volume carbon monoxide.

[0065] The product stream **510'''** may be directed from the mixing valve **413a** to a heat exchanger, such as recuperator **424**, to increase the temperature of the product stream **510'''** such that water therein is converted to high temperature steam. By way of non-limiting example, after passing through the recuperator **424**, the product stream **510'''** may have a temperature in a range of from about 174° C. to about 274° C. Additionally, the product stream **510'''** may be passed through a heater **642** to further heat the components thereof and to convert water that may still be present therein to high temperature steam. The heater **642** may utilize process heat produced by the thermochemical conversion of the carbonaceous fuel in the input **102** to increase the temperature of the product stream **510'''**. By passing the product stream **510'''** through the recuperator **424** and, optionally, the heater **642**, the syngas production system **500** is configured to enable the heat from the product stream **510** produced by the thermochemical conversion apparatus **406** utilized in the electrolysis of steam of the co-electrolysis of steam and carbon dioxide. In this way, the syngas production system **500** is configured to produce syngas in the absence of an external heat source.

[0066] After passing through the recuperator **424** and, optionally, the heater **642**, the components of the product stream **510'''** have a temperature sufficient to enable high temperature co-electrolysis of steam and carbon dioxide. For example, the product stream **510'''** may have a temperature in a range of from about 676.5° C. to about 776.5° C.

[0067] Prior to co-electrolysis, the product stream **510'''** may be directed to a water shift reactor **432** that may employ a conventional ambient cooler **427** to convert water and carbon monoxide in the product stream **510'''** to hydrogen and carbon dioxide, forming a feed stream **426**. The feed stream **426** may include from about 36% to about 56% by volume

water, from about 12% to about 32% by volume hydrogen, from about 11% to about 31% by volume carbon dioxide, and from about 1% to about 21% by volume carbon monoxide.

[0068] The feed stream **426** may be directed to the solid-oxide electrolysis cell array **414**, including one or more solid-oxide electrolysis cells operably coupled to a power source **416** and, optionally, a process heat **408**. The solid-oxide electrolysis cell array **414** may be used to simultaneously decompose water into hydrogen and oxygen and carbon dioxide into carbon monoxide and oxygen. In other words, the water and carbon dioxide may be subjected to co-electrolysis to form an oxygen stream **104** and a syngas **140**. As a non-limiting example, the syngas **140** may include less than about 5% by volume water, from about 58% to about 78% by volume hydrogen, less than about 5% by volume carbon dioxide, and from about 22% to about 42% by volume carbon monoxide.

[0069] The oxygen stream **104** produced by co-electrolysis of water and carbon dioxide may be passed through a gas cleanup (not shown) that facilitates removal of pollutants such as sulfides and remaining carbon dioxide. The oxygen stream **104** may have a temperature in a range of from about 754° C. to about 854° C. upon exiting the solid-oxide electrolysis cell array **414**. The oxygen stream **104** may also be fed through and cooled by the recuperator **424**, the retained heat from which may be employed in heating the product stream **510'''**, as previously described. Subsequent to cooling, the oxygen stream **104** may have a temperature in a range of from about 7° C. to about 107° C. The oxygen stream **104** may be directed to another valve **428b** such that excess oxygen **430** may be discharged from the syngas production system **500** and the remaining oxygen stream **104'** may be fed into the thermochemical conversion apparatus **406**. For example, the thermochemical conversion apparatus **406** may be a gasifier and the amount of oxygen fed into the reaction may be controlled to obtain a desired ratio of carbon dioxide to carbon monoxide in the product stream **510**.

[0070] As illustrated in FIG. 6, a syngas production system **600** may be configured to include a pyrolyzer **606** to convert an input **102**, including a carbonaceous fuel, into a product stream **610**, including a mixed gas. The pyrolyzer **606** may be used to pyrolyze the carbonaceous fuel in the absence of oxygen. Process heat **408** may, optionally, be used to support the pyrolysis of the carbonaceous fuel in the input **102**. The product stream **610** may include, for example, water, hydrogen, carbon dioxide, carbon monoxide, and methane. By way of non-limiting example, the product stream **610** exiting the pyrolyzer **606** may exhibit a temperature in a range of from about 527° C. to about 627° C. and may include less than 5% by volume water, from about 20.5% to about 40.5% by volume hydrogen, less than about 5% by volume carbon dioxide, from about 45% to about 65% by volume carbon monoxide, and from about 3% to about 23% by volume methane.

[0071] The product stream **610** may be directed from the pyrolyzer **606** to a mixing valve **413a**, or other suitable device, such that the product stream **610** may be mixed with a portion **112'** of a hydrogen stream **112**. The hydrogen stream **112** may include hydrogen and steam and may be obtained from high temperature electrolysis of water, as will be described in detail below. As a non-limiting example, the hydrogen stream **112** may be formed using solid-oxide electrolysis cell array **414**, which includes one or more solid-oxide electrolysis cells, connected to a power source **416**, each of which electrolyze water to form hydrogen and oxygen gas. Specifically, a water stream **420** may be converted to

high-temperature steam **218** via a counter-flow heat exchanger, such as a recuperator **424**, or any other device known in the art for exchanging heat between gas and fluid streams. The water stream **420** may be, as an example, directed to the recuperator **424** using a water pump **422** operated using a renewable power source (not shown). Before being passed to the solid-oxide electrolysis cell array **414**, the high temperature steam **218** may be mixed with another portion **112"** of the hydrogen stream **112** cycled from the solid-oxide electrolysis cell array **414** using, for example, another mixing valve **413b**, or other similar piping arrangement to form a feed stream **426**. The feed stream **426** may include, for example, steam and hydrogen and may be fed to the solid-oxide electrolysis cell array **414** such that steam may be decomposed to form the hydrogen stream **112** and the oxygen stream **104**. As a non-limiting example, the feed stream **426** may have a temperature in a range of from about 777° C. to about 877° C. and may include greater than or equal to about 85% water and less than or equal to about 15% hydrogen. Optionally, a heat source **418** may be connected to the one or more solid-oxide electrolysis cell array **414** to facilitate electrolysis of high-temperature steam **218**.

[0072] The oxygen stream **104** may be directed through and cooled by the recuperator **424** before being expelled from the syngas production system **600**. The hydrogen stream **112** may be, for example, directed to a valve **428a** that splits the hydrogen stream **112**, directing a portion **112'** of the hydrogen stream **112** to the mixing valve **413a** to be combined with the product stream **610** and another portion **112"** to another mixing valve **413b** to be mixed with high-temperature steam **218**.

[0073] After combining the product stream **610** with the portion **112'** of the hydrogen stream **112**, the product stream **610'** contains an increased ratio of hydrogen gas. By way of non-limiting example, the product stream **610'** may include less than about 1% water, from about 53% to about 73% hydrogen, less than about 1% carbon dioxide, from about 18% to about 38% carbon monoxide, and less than about 5% methane. The product stream **610'** may be fed into a water shift reactor **432** that converts carbon dioxide and hydrogen to carbon monoxide and water, thus altering the ratio of constituents in the product stream **610'** to form a syngas **140**. By way of non-limiting example, the syngas **140** exiting the water shift reactor **432** may exhibit a temperature in a range of from about 1030° C. to about 1130° C. and may include less than 1% by volume water, from about 53% to about 73% by volume hydrogen, less than about 1% by volume carbon dioxide, from about 18% to about 38% by volume carbon monoxide, and less than about 5% by volume methane.

[0074] The syngas **140** may be passed through and cooled by the recuperator **424** before to being directed to a Fischer-Tropsch process (not shown) which may convert the syngas **140** to a synfuel or any other conventional catalytic process used to form hydrocarbon products. For example, the syngas **140** may have a temperature in a range of from about 209° C. to about 309° C. after exiting the recuperator **424**. By cooling the syngas **140**, the recuperator **424** retains heat produced during thermochemical conversion of the carbonaceous fuel in the input **102**. As previously discussed, the heat from the syngas **140** is transferred to water to create high-temperature steam that may be electrolyzed without applying heat from another, external source. By utilizing heat produced within the syngas production system **600** to perform electrolysis, the syngas production system **600** is not dependent on, and may not be located near, an external heat source. By utilizing heat

from pyrolysis of at least one type of carbonaceous fuel to convert the water stream **420** to high temperature steam that may be electrolyzed by the solid-oxide electrolysis array **414**, the reliance on an outside heat source is substantially reduced. Conventionally, a high temperature power plant, such as a nuclear power plant, may be used to produce hydrogen for syngas. Because hydrogen is highly flammable, storage, production and use of hydrogen near a nuclear power plant may be problematic. In the syngas production system **600**, the pyrolyzer **606** may be located near the solid-oxide electrolysis cell array **414**, thus eliminating problems associated with the production, storage and use of hydrogen near a nuclear power plant.

[0075] The following examples serve to explain embodiments of the invention in more detail. These examples are not to be construed as being exhaustive or exclusive as to the scope of this invention.

EXAMPLES

[0076] The five examples set forth below provide nonlimiting examples of systems having the ability to utilize heat generated from the combustion, gasification or pyrolyzation of a carbonaceous fuel to support the electrolysis of water or the co-electrolysis of water and carbon dioxide. The modeling software UNISIM, which is commercially available from Honeywell International Inc. (Morristown, N.J.), was used to model the processes of each of the examples. In each of the examples, the feed stream includes cellulose. The so-called "syngas production efficiency" for each of the systems was calculated using the following equation: $[(HHV_{syngas}) \times (\text{flowrate of syngas})] / [(HHV_{cellulose}) \times (\text{flowrate of cellulose}) + (\text{electrical power (watts)} / 0.30)]$, wherein the HHV is the higher heating value (i.e., the heat released from cellulose during combustion). The syngas production efficiency provides a means of comparing the electrical energy fed into the solid-oxide electrolysis cell array per unit of syngas output for the syngas production process discussed in Examples 1 through 5 with one another.

Example 1

High Temperature Co-Electrolysis with Gasifier and Cleanup

[0077] Modeling was conducted for a syngas production process **300** using a gasifier as the thermochemical combustion apparatus **406**. As previously noted, the syngas production system **300** utilized heat produced by gasification of a carbonaceous fuel to support high temperature electrolysis using a solid-oxide electrolysis cell array **414**. Specifically, the heat generated during the gasification of a carbonaceous fuel was harnessed and transferred to the feed stream **426** using the recuperator **424**.

[0078] Referring back to FIG. 3, conditions or "state points" of fluid flowing throughout the syngas production system **300** are now described. The input **102** including cellulose as the carbonaceous fuel entered the syngas production system **300** at a pressure of about 2758 kPa, at a temperature of about 21.15° C. and at a mass flow rate of about 583.7 kilograms per hour (kg/h).

[0079] Gasification of the input **102** provided a product stream **310** including a mole fraction composition of about 0.277 water, about 0.1776 hydrogen, about 0.1776 carbon dioxide and about 0.3679 carbon monoxide. At a location between a gasifier, which was employed as the thermochemi-

cal conversion apparatus **406**, and the mixing valve **413a**, the product stream **310** exhibited a temperature of about 1370.85° C. and a pressure of about 2758 kPa. The product stream **310** was mixed with the portion **112'** of the hydrogen stream **112** such that the product stream **310'** included a mole fraction composition of about 0.1533 water, about 0.5592 hydrogen, about 0.0936 carbon dioxide, and about 0.1939 carbon monoxide and was fed to a water shift reactor **432** at a pressure of about 2758 kPa, a temperature of about 1115° C., and a mass flow of about 1010 kg/h.

[0080] After exiting the water shift reactor **432** and prior to passing through the recuperator **424**, the product stream **310"** exhibited a temperature of about 1072.85° C. and a pressure of about 2758 kPa. As previously described, the recuperator **424** caused a reduction in temperature of the product stream **310"**. As such, the product stream **310"** exhibited a temperature of about 176° C. and a pressure of about 2758 kPa after passing through the recuperator **424**. The product stream **310"** was passed through the water knockout tank **436** to remove excess water **438**. The syngas **140** exiting the water knockout tank **436** includes a mole fraction composition of about 0.0013 water, about 0.6397 hydrogen, about 0.0577 carbon dioxide, and about 0.3012 carbon monoxide and exhibited a temperature of about 25° C. and a pressure of about 2758 kPa and had a mass flow of about 739.3 kg/h. Table 1 provides a summary of the syngas **140** constituents as well as efficiency data for syngas production using the syngas production system **300**.

TABLE 1

Hydrogen:Carbon Monoxide Ratio	2.124:1
Syngas Production Efficiency	42.43%
gmol Syngas/(gmol Cellulose * Watt (electric))	7.036

[0081] Prior to passing through the recuperator **424**, the water stream **420** exhibited a temperature of about 21° C., a pressure of about 101.3 kPa and a mass flow of about 640.2 kg/h. After exiting the recuperator **424**, the temperature of the high-temperature steam **218** was about 831° C. At a location between the another mixing valve **413b** and the solid-oxide electrolysis cell array **414**, the feed stream **426** included a mole fraction composition of about 0.95 steam and about 0.05 hydrogen and exhibited a temperature of approximately 827° C.

[0082] An electrical current of 2362 kW was supplied to the solid-oxide electrolysis cell array **414** using a remotely-located power source. The solid-oxide electrolysis cell array **414** included 6.0×10^4 solid-oxide electrolysis cells, each solid-oxide electrolysis cell having an area of 225.0 cm² and a current density of 0.1389 amperes/cm². The hydrogen stream **112** exiting the solid-oxide electrolysis cells **414** included a mole fraction composition of about 0.0155 water and about 0.9845 hydrogen and exhibited a temperature of about 731° C. and a pressure of about 2758 kPa and had a mass flow of about 80.44 kg/h. The oxygen stream **104** exiting the recuperator **424** exhibited a temperature of about 731° C. and a pressure of about 2758 kPa and had a mass flow of about 559.8 kg/h at a location between the solid-oxide electrolysis cells **314** and the recuperator **424**.

[0083] After passing through the recuperator **424**, the temperature of the oxygen stream **104** was reduced to about 77° C. Conventional ambient cooling **434** used to support the water knockout tank **436** further reduces the temperature of

the oxygen stream **104**, such that the oxygen stream **104** exhibited a temperature of about 21° C.

Example 2

High Temperature Steam Electrolysis Injecting Hydrogen Gas into a Gasifier

[0084] Modeling was also conducted for a syngas production system **400** using a gasifier as the thermochemical conversion apparatus **406**. The syngas production system **400** utilized the heat produced by thermochemical conversion of a carbonaceous fuel to support electrolysis using one or more solid-oxide electrolysis cells. For example, heat generated during the gasification of a carbonaceous fuel may be utilized to convert water to steam using a heat exchanger.

[0085] Referring to FIG. 4, conditions or "state points" of fluid flowing throughout the syngas production system **400** are now described. The input **102** including cellulose and oxygen stream **104** exhibited a pressure of about 2758 kPa, at a temperature of about 22° C. when entering the gasifier used as the thermochemical conversion apparatus **406**. The mass flow rates of the input **102** and oxygen stream **104** were, respectively, about 583.7 kg/h and about 345.6 kg/h. The hydrogen stream **112** exiting the solid-oxide electrolysis cell array **414** included a mole fraction composition of about 0.0539 water and about 0.946 hydrogen and exhibited a temperature of about 762° C. and a mass flow of about 115.3 kg/h.

[0086] The product stream **410** exiting the gasifier included a mole fraction composition of about 0.221 water, about 0.5078 hydrogen, about 0.0322 carbon dioxide, about 0.2389 carbon monoxide, and 0.0001 methane. The product stream **410** exited the gasifier at a temperature of about 1371° C. and a pressure of about 2758 kPa and at a mass flow of about 1045 kg/h. The water shift reactor **432**, as described above, converted carbon dioxide and hydrogen to carbon monoxide and water and, thus, the product stream **410'** that exited the water shift reactor **432** included a mole fraction composition of about 0.2215 water, about 0.5073 hydrogen, about 0.0317 carbon dioxide, about 0.2394 carbon monoxide, and about 0.0001 methane.

[0087] After being passed through the recuperator **424**, the product stream **410'** exhibited a temperature about 459° C. before being passed through the water knockout tank **436**. The syngas **140** exiting the water knockout tank **436** included a mole fraction composition of about 0.0013 water, about 0.6509 hydrogen, about 0.0406 carbon dioxide, about 0.3071 carbon monoxide, and about 0.0001 methane and exhibited a temperature of about 25° C. Table 2 provides a summary of the syngas constituents as well as efficiency data for syngas production using the syngas production system **400**.

TABLE 2

Hydrogen:Carbon Monoxide Ratio	2.120:1
Syngas Production Efficiency	40.84%
gmol Syngas/(gmol Cellulose * Watt (electric))	6.548

[0088] A water stream **420** at a temperature of about 21° C. was passed through the recuperator **424** and exited the recuperator **424** as high-temperature steam **218** that exhibited a temperature of about 830° C. At a location between the mixing valve **413a** and the solid-oxide electrolysis cell array **414**, the feed stream **426** included a mole fraction composition of about 0.95 water and about 0.05 hydrogen.

[0089] An electrical current of about 2574 kW was provided to the solid-oxide electrolysis cell array **414** by a remote power source. The solid-oxide electrolysis cell array **414** included about 6.00×10^4 solid-oxide electrolysis cells, each having an area of about 225.0 cm^2 such that the current density was about $0.1505 \text{ amperes/cm}^2$. The hydrogen stream **112** exiting the solid-oxide electrolysis cell array **414** included a mole fraction composition of about 0.0539 water and about 0.9461 hydrogen and exhibited a temperature of 762°C . and a pressure of about 2758 kPa. The oxygen stream **104** exiting the solid-oxide electrolysis cell array **414** exhibited a temperature of 762°C . and a pressure of about 2758 kPa. After passing through the recuperator **424**, the oxygen stream **104** exhibited a temperature of about 77°C . The excess oxygen **430** was passed through an ambient cooler **427** and exhibited a temperature of about 21°C . upon exiting the system.

Example 3

High-Temperature Co-Electrolysis of Steam and Carbon Dioxide Using a Gasifier

[0090] Modeling was also conducted for a syngas production system **500** using a gasifier as the thermochemical conversion apparatus **406**. The syngas production system **500** utilized the heat generated during gasification of a carbonaceous fuel to support high temperature co-electrolysis of steam and carbon dioxide using one or more solid-oxide electrolysis cells.

[0091] Referring to FIG. 5, conditions or “state points” of fluid flowing throughout the syngas production system **500** are now described. Input **102** exhibited a pressure of about 2758 kPa a temperature of about 21°C . and at a mass flow rate of about 583.7 kg/h upon entering the a gasifier employed as a thermochemical conversion apparatus **406**. The input **102** was gasified to form a product stream **510** that included a mole fraction composition of about 0.277 water, about 0.1776 hydrogen, about 0.1776 carbon dioxide, and about 0.3679 carbon monoxide. Upon exiting the gasifier **406**, the product stream **510** exhibited a temperature of about 1371°C . and a pressure of about 2758 kPa and had a mass flow of about 929.3 kg/h.

[0092] A water stream **420'** entered the quencher **509** exhibited a temperature of about 21°C ., a pressure of about 2758 kPa and a mass flow of about 12970 kg/h. The product stream **510'** exited the quencher **509** at a temperature of about 65°C . and a pressure of about 2758 kPa. The product stream **510'** was fed from the quencher **509** to the water knockout tank **436** at a mass flow of about 13900 kg/h.

[0093] The excess water **438** exiting the water knockout tank **436** included a mole fraction composition of about 0.9986 water and about 0.0013 carbon dioxide. The product stream **510''** exiting the water knockout tank **436** included a mole fraction composition of about 0.011 water, about 0.2515 hydrogen, about 0.2174 carbon dioxide, and about 0.5201 carbon monoxide. At a location between the mixing valve **413a** and the recuperator **424**, the product stream **510'''** included a mole fraction composition of about 0.5702 water, about 0.1093 hydrogen, about 0.0945 carbon dioxide, and about 0.226 carbon monoxide and exhibited a temperature of about 35°C . The product stream **510'''** exited the recuperator **424** at a temperature of about 224°C . and a pressure of about

2758 kPa. The product stream **510'''** was passed through the heater **642** such that the temperature was increased to about 726°C .

[0094] The product stream **510'''** was passed to a water shift reactor **432** which, as described above, converted carbon monoxide and water to carbon dioxide and hydrogen. After being passed through the water shift reactor **432**, the feed stream **426** included a mole fraction composition of about 0.4548 water, about 0.2247 hydrogen, about 0.2099 carbon dioxide, and about 0.1106 carbon monoxide.

[0095] The feed stream **426** entered the solid-oxide electrolysis cell array **414** at a temperature of about 827°C ., a pressure of about 2758 kPa and a mass flow of about 1349 kg/h. The solid-oxide electrolysis cell array **414** had a current density of about $0.1690 \text{ amperes/cm}^2$ and included about 6.00×10^4 total cells, each with an area of about 225.0 cm^2 .

[0096] The products of electrolysis were separated to form an oxygen stream **104** and syngas **140** that was flowed through and cooled by the recuperator **424**. The oxygen stream **104** was passed from the recuperator **424** to another valve **428b** at a temperature of about 57°C . such that oxygen entered the gasifier having a mass flow of about 346 kg/h.

[0097] The syngas **140'** that exited the recuperator **424** included a mole fraction composition of about 0.0019 water, about 0.6776 hydrogen, about 0.0009 carbon dioxide, and about 0.319 carbon monoxide. The syngas **140'** exhibited a temperature of about 57°C . at a pressure of about 2758 kPa and a mass flow of about 668.2 kg/h. Table 3 provides a summary of the syngas **140** constituents as well as efficiency data for syngas production using the gasifier in the syngas production system **500**.

TABLE 3

Hydrogen:Carbon Monoxide Ratio	2.120:1
Potential Electric Power Generation	27.48 kW
Syngas Production Efficiency	38.39%
gmol Syngas/(gmol Cellulose * Watt (electric))	5.897

Example 4

High-Temperature Co-Electrolysis of Steam and Carbon Dioxide Using a Combustor

[0098] Modeling was also conducted for a syngas production system **500** using a combustor as the thermochemical conversion apparatus **406**. The syngas production system **500** employed a heat exchanger to harness the heat produced during thermochemical conversion of a carbonaceous fuel to support electrolysis using one or more solid-oxide electrolysis cells. For example, heat generated during the combustion of a carbonaceous fuel with oxygen may be utilized to perform high temperature co-electrolysis of steam and carbon dioxide using solid-oxide electrolysis cells.

[0099] Referring to FIG. 5, conditions or “state points” of fluid flowing throughout the syngas production system **500** are now described. The input **102** entered a combustor at a pressure of about 2758 kPa, a temperature of about 21°C . and at a mass flow rate of about 583.7 kg/h. The input **102** was combusted to form a product stream **510** that included a mole fraction composition of about 0.277 water, about 0.1776 hydrogen, about 0.1776 carbon dioxide, and about 0.3679 carbon monoxide. The product stream **510** exited the combustor at a temperature of about 1371°C ., a pressure of about 2758 kPa and a mass flow of about 1274 kg/h. A water stream

420' at a temperature of about 21° C. and a pressure of about 2758 kPa was fed into the quencher **509** with the product stream **510** at a mass flow of 12970 kg/hr. The product stream **510'** exiting the quencher **509** exhibited a temperature of about 78° C. at a pressure of about 2758 kPa. The product stream **510'** was fed from the quencher **509** into the water knockout tank **436** at a mass flow of about 14240 kg/hr where waste water **438** was removed.

[0100] After removal of the waste water **438**, the product stream **510"** exiting the water knockout tank **436** included a mole fraction composition of about 0.0209 water, about 0.0008 hydrogen, about 0.9752 carbon dioxide, and about 0.0032 carbon monoxide. The product stream **510"** was fed into a mixing valve **413a** and mixed with water stream **420"** such that the product stream **510'''** exiting the mixing valve **413a** included a mole fraction composition of about 0.6792 water, about 0.0003 hydrogen, about 0.3195 carbon dioxide, and about 0.001 carbon monoxide.

[0101] The product stream **510'''** exhibited a temperature of about 37° C. upon entering the recuperator **424**. After exiting the recuperator **424** the product stream **510'''** exhibited a temperature of about 296° C. at a pressure of about 2758 kPa. The product stream **510'''** was passed through the heater **642**. The product stream **510'''** exiting the heater **642** was about 827° C.

[0102] The heated product stream **510'''** was passed through the water shift reactor **432** which, as described above, converts carbon monoxide and water to carbon dioxide and hydrogen. Upon exiting the water shift reactor **432**, the feed stream **426** included a mole fraction composition of about 0.6786 water, about 0.0009 hydrogen, about 0.3201 carbon dioxide, and about 0.0004 carbon monoxide. The feed stream **426** was directed into the solid-oxide electrolysis cell array **414** at a temperature of about 827° C., a pressure of about 2758 kPa and a mass flow of about 1461 kg/h. The solid-oxide electrolysis cell array **414** had a current density of about 0.1690 amperes/cm² and included about 6.00×10⁴ total cells, each with an area of about 225.0 cm².

[0103] The products of electrolysis were separated to form an oxygen stream **104** and syngas **140** that were flowed through and cooled by the recuperator **424**. At a location between the recuperator **424** and another valve **428b**, the oxygen stream **104** exhibited a temperature of about 57° C. and a mass flow of about 886 kg/h.

[0104] The syngas **140'** exiting the recuperator **424** included a mole fraction composition of about 0.0002 water, about 0.6794 hydrogen, about 0.0001 carbon dioxide, and about 0.3204 carbon monoxide. The syngas **140'** exhibited a temperature of about 57° C. at a pressure of about 2758 kPa and a mass flow of about 574.4 kg/h. Table 4 provides a summary of the syngas **140** constituents as well as efficiency data for the syngas production system **500**.

TABLE 4

Hydrogen:Carbon Monoxide Ratio	2.120:1
Potential Electric Power Generation	465.7 kW
Syngas Production Efficiency	29.13%
gmol Syngas/(gmol Cellulose * Watt (electric))	4.305

Example 5

High Temperature Steam Electrolysis Using Pyrolyzer

[0105] Modeling was also been conducted for a syngas production system **600** that utilized the heat produced during

pyrolyzation of a carbonaceous fuel to support electrolysis using one or more solid-oxide electrolysis cells.

[0106] Referring to FIG. 6, conditions or "state points" of fluid flowing throughout the syngas production system **600** are now described. The input **102** was fed into the pyrolyzer **606** at a temperature of about 21° C., a pressure of about 2758 kPa and a mass flow of about 583.7 kg/h. After pyrolyzation, the product stream **610** included a mole fraction composition of about 0.0077 water, about 0.305 hydrogen, about 0.0078 carbon dioxide, about 0.5495 carbon monoxide and 0.13 methane. Before entering the mixing valve **413a**, the product stream **610** exhibited a temperature of about 1027° C. at a pressure of about 2758 kPa and a mass flow of about 583.7 kg/h.

[0107] The water stream **420** exhibiting a temperature of about 21° C., a pressure of about 101.3 kPa and a mass flow about 561.5 kg/h was passed through and heated by the recuperator **424** to form high temperature steam **218**. Upon exiting the recuperator **424**, the high-temperature steam **218** had a temperature of 814° C., a pressure of about 3000 kPa and a mass flow of about 561.5 kg/h. The high-temperature steam **218** was fed into the mixing valve **413b** with another portion **112'** of the hydrogen stream **112** to form a feed stream **426** that included a mole fraction composition of about 0.95 water and about 0.05 hydrogen.

[0108] The feed stream **426** was passed through the solid-oxide electrolysis array **414** at a temperature of about 827° C. at a pressure of about 3000 kPa and had a mass flow of about 566.4 kg/h. The solid oxide-electrolysis cell array **414** had a current density of about 0.2480 amperes/cm² and included about 1.00×10⁵ total cells, each with an area of about 64.0 cm². The oxygen stream **104** and the hydrogen stream **112** exited the solid-oxide electrolysis cell array **414** at a temperature of about 1142° C. The oxygen stream **104** was passed through the recuperator **424** and was cooled to a temperature of about 197° C. The hydrogen stream **112** exited the solid-oxide electrolysis cell array **414** and was split into the portion **112'** of the hydrogen stream **112** and the other portion **112"** of the hydrogen stream **112**. Hydrogen streams **112'** and **112"** exited flow splitting device **428a** at 1142° C. and 3000 kPa and a mass flow rate of 87.8 kg/h and 4.9 kg/h, respectively.

[0109] The product stream **610'** was fed into a mixing valve **413a** with the portion of the hydrogen stream **112'**, which exhibited a temperature of about 1142° C., a pressure of about 3000 kPa and a flow rate of about 87.77 kg/h. Upon exiting the mixing valve **413b**, the product stream **610'** included a mole fraction composition of about 0.0288 water, about 0.6262 hydrogen, about 0.0039 carbon dioxide, about 0.2759 carbon monoxide and 0.0653 methane.

[0110] The product stream **610'** was passed through the water shift reactor **432** that converted carbon dioxide and hydrogen in the product stream **610'** to carbon monoxide and water, which exited as syngas **140**. The syngas **140** exiting the water shift reactor **432** included a mole fraction composition of about 0.027 water, about 0.628 hydrogen, about 0.0057 carbon dioxide, about 0.2741 carbon monoxide and about 0.0653 methane. At a location between the water shift reactor **432** and the recuperator **424**, the syngas **140** exhibited a temperature of about 1080° C. at a pressure of about 2758 kPa and has a mass flow of about 671.5 kg/h. Upon exiting the recuperator **424**, the syngas **140** was at a temperature of about 214° C. Table 5 provides a summary of the syngas **140** constituents as well as efficiency data for the syngas production system **600**.

TABLE 5

Hydrogen:Carbon Monoxide Ratio	2.291
Syngas Production Efficiency	44.29%

[0111] While the invention may be susceptible to various modifications and alternative forms, specific embodiments have been shown by way of example in the drawings and have been described in detail herein. However, it should be understood that the invention is not intended to be limited to the particular forms disclosed. Rather, the invention is to cover all modifications, equivalents, and alternatives falling within the scope of the invention as defined by the following appended claims and their legal equivalents.

What is claimed is:

1. A method for producing syngas, comprising:
thermochemically converting a carbonaceous fuel to produce heat and a mixed gas comprising water, hydrogen, carbon monoxide and carbon dioxide;
exposing a water stream to the heat from the thermochemical conversion of the carbonaceous fuel to produce steam;
introducing the steam to at least one solid-oxide electrolysis cell;
decomposing the steam in the at least one solid-oxide electrolysis cell to produce hydrogen and oxygen; and
combining at least a portion of the carbon monoxide from the mixed gas with at least a portion of the hydrogen to produce syngas.
2. The method of claim 1, wherein the water stream is boiler feed water.
3. The method of claim 1, wherein thermochemically converting a carbonaceous fuel to produce heat and a mixed gas comprises gasifying the carbonaceous fuel.
4. The method of claim 3, further comprising recirculating a portion of the oxygen produced by decomposing steam in the at least one solid-oxide electrolysis cell to the gasification process.
5. The method of claim 1, wherein exposing the water to the heat from the thermochemical conversion of the carbonaceous fuel to produce steam comprises heating the water to produce steam having a temperature in a range of from about 500° C. to about 1200° C.
6. The method of claim 1, wherein exposing the water to the heat from the thermochemical conversion the carbonaceous fuel to produce steam comprises transferring the heat from the mixed gas to the water.
7. The method of claim 1, further comprising:
introducing carbon dioxide at a temperature between about 500° C. and about 1200° C. to the at least one solid-oxide electrolysis cell; and
decomposing the carbon dioxide to produce carbon monoxide and oxygen.
8. The method of claim 1, wherein combining at least a portion of the carbon monoxide from the mixed gas with at least a portion of the hydrogen to form syngas having a ratio of hydrogen to carbon monoxide in the range of 1.7:1 to 2.12:1.

9. A method for forming syngas, comprising:
producing heat and a mixed gas comprising carbon dioxide, carbon monoxide, water and hydrogen by gasifying a carbonaceous fuel;
condensing the mixed gas to remove at least one impurity from the mixed gas and to generate a feed stream;
transferring the heat produced by gasifying the carbonaceous fuel to the feed stream to convert at least a portion of the water in the feed stream to steam;
introducing the feed stream to at least one solid-oxide electrolysis cell;
electrolyzing carbon dioxide and steam in the feed stream in at least one solid-oxide electrolysis cell to produce carbon monoxide, hydrogen and oxygen;
separating the carbon monoxide and hydrogen from the oxygen.

10. The method of claim 9, further comprising transferring heat from the carbon monoxide, hydrogen and oxygen produced in the at least one solid-oxide electrolysis cell to the feed stream.

11. The method of claim 9, further comprising contacting the mixed gas with a water stream having a temperature substantially lower than a temperature of the mixed gas to cool the mixed gas.

12. The method of claim 9, producing heat and a mixed gas comprising carbon dioxide, carbon monoxide, water and hydrogen by gasifying a carbonaceous fuel comprises gasifying the carbonaceous fuel in the presence of a portion of the oxygen formed by electrolyzing carbon dioxide and steam control a ratio of carbon monoxide and hydrogen produced by electrolyzing carbon dioxide and steam.

13. A process for forming syngas, comprising:
thermochemically converting a carbonaceous fuel to produce heat and a mixed gas comprising carbon dioxide, carbon monoxide, hydrogen and water;
transferring the heat to a water stream to produce steam;
electrolyzing the steam to produce hydrogen and oxygen;
converting at least a portion of the carbon dioxide and hydrogen in the mixed gas to carbon monoxide and water;
cooling the mixed gas; and
removing water from the mixed gas to form syngas.

14. The method of claim 13, wherein thermochemically converting a carbonaceous fuel to produce heat and a mixed gas comprising carbon dioxide, carbon monoxide, water and hydrogen comprises at least one of combusting, gasifying or pyrolyzing the carbonaceous fuel.

15. The method of claim 13, further comprising mixing the steam with at least a portion of the hydrogen produced by electrolyzing steam.

16. The method of claim 13, further comprising directing a portion of the oxygen produced by electrolyzing the steam to the thermochemical conversion of the carbonaceous fuel to control the ratio of carbon dioxide to carbon monoxide in the mixed gas.

17. The method of claim 13, wherein transferring the heat produced by thermochemically converting the carbonaceous fuel to a water stream to produce steam comprises transferring the heat produced by thermochemically converting the carbonaceous fuel to the water stream to produce steam having a temperature of from about 500° C. to about 1200° C.

18. The method of claim 13, wherein converting at least a portion of the carbon dioxide and hydrogen in the mixed gas

to produce carbon monoxide and water comprises altering the ratio of hydrogen to carbon monoxide in the mixed gas in the range of 1.7:1 to 2.12:1.

19. A method for producing a hydrogen gas, comprising:
gasifying a carbonaceous fuel to produce a mixed gas comprising carbon monoxide, carbon dioxide, hydrogen, water and high-temperature steam;
removing at least a portion of the high-temperature steam from the mixed gas;
electrolyzing the at least a portion of the high-temperature steam in at least one solid-oxide electrolysis cell to form hydrogen and oxygen;
converting at least a portion of the water in the mixed gas to hydrogen; and
removing at least one impurity from the mixed gas.

20. A system for producing syngas, comprising:
an apparatus configured to thermochemically convert a carbonaceous fuel into heat and a mixed gas comprising carbon dioxide, carbon monoxide, hydrogen and water;
a heat exchange device configured to transfer the heat produced during the conversion of the carbonaceous fuel to at least one of the carbon dioxide and water; and

at least one solid-oxide electrolysis cell operably coupled to at least one power source and configured to electrolyze at least one of water and carbon dioxide to form oxygen and at least one of hydrogen and carbon monoxide.

21. The system of claim **20**, wherein the apparatus for converting the carbonaceous fuel is selected from the group comprising a combustor, a gasifier, and a pyrolyzer.

22. The system of claim **20**, wherein the heat exchange device comprises a counter-flow heat exchanger.

23. The system of claim **20**, further comprising an apparatus configured to convert carbon dioxide and hydrogen to carbon monoxide and water.

24. The system of claim **20**, further comprising an apparatus for directing a portion of the oxygen to the apparatus to alter the ratio of carbon dioxide to carbon monoxide in the mixed gas.

25. The system of claim **20**, wherein the at least one solid-oxide electrolysis cell is operably connected to at least one power source including a nuclear power source, hydro power source, and wind power source.

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